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AD853956

FRACTURE TOUGHNESS, FATIGUE AND CORROSION
CHARACTERISTICS OF HIGH STRENGTH ALUMINUM
EXTRUSIONS AND PLATE

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Contract No. F33615-67-C-1521-
Eighth Quarterly Technical Management Report
December 27, 1968 to March 27, 1969

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ABSTRACT

Axial-stress fatigue curves are reported for notched ($K_t = 3$) specimens from the 7075-T6510, 7075-T73510, X7080-T7E42, and 7178-T6510 extruded bars. The fatigue properties generally varied with direction in the same order as the tensile properties. All of the fatigue crack propagation data are reported and analyzed. For both the extruded shapes and the plate, crack propagation was faster for transverse than for longitudinal specimens. Machining to remove the extruded or rolled surfaces, taking specimens from the center of thickness of the thicker extrusions, and varying the thickness of the products, did not consistently affect the crack propagation rates. For extrusions and plate, the four alloys are rated in the following order of decreasing resistance to fatigue crack propagation:

7075-T73-type
X7080-T7-type
7075-T6-type
7178-T6-type

The tests to evaluate stress-corrosion resistance by a fracture-mechanics approach are nearly completed. Test results from bolt-loaded and ring-loaded specimens from the short-transverse direction of the extruded bars generally rated the four samples in the same order as the conventional stress-corrosion tests of smooth tensile specimens. The 7075-T6510 and 7178-T6510 extruded bars were definitely susceptible to stress-corrosion cracking when stressed in the short-transverse direction. The short-transverse direction of the X7080-T7E42 extruded bar showed slight susceptibility to stress-corrosion cracking. The 7075-T73510 extruded bar was apparently immune.

This is the last quarterly report to be issued on this contract. The final report will be completed by July 27, 1969.

TABLE OF CONTENTS

	<u>Page</u>
I. INTRODUCTION AND OBJECT	1
II. MATERIAL	1
III. TEST PROGRAM	2
IV. PROGRESS DURING THIS QUARTER	3
A. Fracture Toughness	3
B. Axial-Stress Fatigue	4
C. Fatigue Crack Propagation	5
D. Corrosion Characteristics	11
1. Exfoliation and Stress Corrosion	11
2. Stress-Corrosion Fracture Toughness	16
V. PROGRAM FOR NEXT QUARTER	19
VI. TABLES AND FIGURES	21

QUARTERLY REPORT

FRACTURE TOUGHNESS, FATIGUE AND CORROSION CHARACTERISTICS OF 7075-T6510, 7075-T73510, X7080-T7510 AND 7178-T6510 EXTRUSIONS AND X7080-T751 AND 7178-T651 PLATE

I. Introduction.

Fracture toughness, fatigue and corrosion characteristics are among the most important properties in determining the suitability of materials for many aerospace applications. The purpose of this contract is to provide data for extrusions and plate of several alloys and tempers which appear potentially suitable for such applications. The data obtained are not design or expected minimum values of the properties involved, but rather the results of tests of representative lots of material. As such, the data should be interpreted as representative values rather than statistically reliable average or minimum values of the properties involved.

The effort during the first twenty-one months on this program was described in seven previous quarterly reports.⁽¹⁻⁷⁾ The fourth quarterly report⁽⁴⁾ summarized the effort of the program's first year. This report describes the progress during the eighth quarter of the contract, from December 27, 1968 to March 27, 1969. This is the last quarterly report which will be issued. The final report will be submitted by July 27, 1969.

II. Material.

All materials were received before this quarter began; the specific items are listed below.

(1-7) Numbers in parentheses pertain to references.

<u>Product</u>	<u>Alloys and Tempers Received</u>
1/2-in. and 1-3/8-in. thick plate	7178-T651; X7080-W51
11/16x16-in. integrally stiffened extruded panel	7075-T6510; 7075-T73510; 7178-T6510; X7080-W510
3-1/2x7-1/2-in. extruded bar	7075-T6510; 7075-T73510; 7178-T6510; X7080-W511

Following studies to determine proper aging treatments for the X7080 plate and extruded shapes, these products were aged from the W51-type to the T7-type tempers. The samples being used were aged during the second and fourth quarters of the contract. (2,4)

The tensile properties of the contract materials were determined previously, (2,4) and are presented for reference in Table I.

III. Test Programs.

The test specimens and procedures being used are substantially as described in the previous quarterly reports, (1-7) except as noted below.

During the eighth quarter of the contract, stress-corrosion specimens from the plate samples completed one year of exposure to the inland industrial atmosphere at New Kensington, Pennsylvania. During the next quarter, other stress-corrosion specimens which are being exposed to the atmosphere at New Kensington and at Point Judith, Rhode Island (except some long-transverse specimens from the 11/16x16-in. extruded panels), will complete one exposure. The stress-corrosion data which

have been obtained thus far from tests in the atmosphere appear to correlate well with the accelerated stress-corrosion test results. Combinations of alloy-temper and stress level which produced specimen failures in accelerated tests also produced specimen failures in the atmosphere. However, longer periods of exposure in the atmosphere are advisable, to develop more reliable correlations with the accelerated stress-corrosion test results. Continuation of the atmospheric tests requires only routine, periodic inspection for failures. Therefore, the stress-corrosion specimens which have survived one year of exposure to the atmosphere at New Kensington or at Point Judith, will be left in test for at least four years, and possibly longer, to obtain information on long-time atmospheric exposure.

IV. Progress During This Quarter.

All test specimens have been machined from the contract materials. All phases of the contract test programs are now either underway or complete.

A. Fracture Toughness

The testing of notch-bend fracture toughness specimens was completed during the fifth quarter. A detailed analysis of the data was included in the Seventh Quarterly Technical Management Report.⁽⁷⁾ The four alloy-temper combinations were placed in the following order of decreasing fracture toughness, for each product:

X7080-T7-type
7075-T73-type
7075-T6-type
7178-T6-type

B. Axial-Stress Fatigue

The axial-stress fatigue tests of specimens from the 1/2 and 1-3/8-in. plate samples, and the 11/16x16-in. extruded integrally stiffened panels, were completed during previous quarters. The S-N curves and modified Goodman diagrams were reported in the Fourth and Fifth Quarterly Technical Management Reports. (4,5)

The axial-stress fatigue tests of smooth specimens from the 3-1/2x7-1/2-in. extruded bars were completed last quarter. The results were reported in the Sixth and Seventh Quarterly Technical Management Reports. (6,7)

The axial-stress fatigue tests of the notched specimens from the extruded bars are in progress. The tests of the $K_t = 3$ notched specimens are nearly completed. The S-N curves and modified Goodman diagrams are shown in Figs. 1 through 24. Specimens from the longitudinal, long-transverse and short-transverse directions, from the center two-thirds of the cross-section of each bar, were tested at three stress ratios, $R = +0.5, 0.0$, and -1.0 ($R = \text{minimum stress/maximum stress}$). Separate modified Goodman diagrams have been prepared for each direction in each sample.

The fatigue lives of specimens from the three directions of each bar were generally ordered in the same way as the

tensile properties. The longitudinal specimens generally had longer lives than the long-transverse specimens, which generally had longer lives than the short-transverse specimens. At higher stress levels, the longitudinal and long-transverse fatigue properties of each sample were quite similar, while the short-transverse fatigue properties were quite dissimilar for all of the materials except the X7080-T7E42 sample. Based on the fatigue strengths of $K_t = 3$ specimens from the extruded bars at 10^7 cycles, the alloys and tempers can be rated in the following order of decreasing fatigue strength:

7075-T6510
X7080-T7E42
7178-T6510
7075-T73510

The order does not hold true for all directions in each product, nor at all individual stress levels or stress ratios; rather, it is an approximate general ranking.

The axial-stress fatigue tests of the $K_t = 12$ notched specimens from the extruded bar samples are in progress. The following numbers of tests have been completed:

7075-T6510	28 of 90
7075-T73510	23 of 90
X7080-T7E42	49 of 90
7178-T6510	18 of 90

C. Fatigue Crack Propagation

The numbers of cycles required to initiate the fatigue cracks in each crack propagation specimen are listed in Table II.

The length of the crack when first observed in each specimen was generally short, but the lengths varied substantially from specimen to specimen. To obtain a common reference for crack growth analysis, each set of data was extrapolated linearly to a zero crack length (notch = 16.7 per cent of gross width) using the first three data points. Fatigue cycles for crack propagation were referred to this calculated initial number of cycles. Fatigue crack propagation curves showing per cent of area cracked on a logarithmic scale versus number of cycles, are plotted in Figs. 25 through 36.

Some of the alloys show considerable scatter for replicate specimens, whereas there is relatively little scatter in the results for others. The data for specimens L2 and T2 in Fig. 29 (7075-T6510, 11/16x16-in. extruded panel) demonstrate the fact that cracking at only one side of the original machined notch can significantly affect its behavior. The total propagation was much slower when there was propagation on only one side of the notch. In the later stages of cracking, however, the eccentricity generally caused faster propagation. Further, final fracture occurred at a shorter total crack length.

Investigations such as that of Ref. 8 have shown that water vapor in the atmosphere can affect the rate of crack propagation. The range of relative humidity which was measured during the crack propagation tests of each specimen is included on Figs. 25 through 36. For specimens where there was a significant variation between the humidities for replicate test specimens having comparable eccentricities, such as specimens T1 and T2 of

Fig. 26 (1-3/8-in. X7080-T7E41 plate), it was observed that the cracks did propagate somewhat faster at the higher humidities.

In Fig. 37, the data for one of the 7075-T7351 specimens from Fig. 32 is replotted using a larger scale for the cycles. As is illustrated, substantial portions of the data can be represented by straight lines. Accordingly, to determine the rates of crack propagation, a computer program was written to determine the slope of the best straight line which could be fit to the logarithms of the crack length versus the number of cycles by the least squares method. To obtain the rate of crack propagation at a certain total crack length (crack length plus machined notch), a straight line was fit to the data for those points which were within 0.30 in. (10 per cent of the gross width) of that total crack length. For example, for a total crack length of 0.90 in. (30 per cent of the gross width), a straight line was fit to the data for total crack lengths from 0.60 in. to 1.20 in. (20 to 40 per cent of gross width).

Log-log plots of the rate of propagation versus ΔK , the range of stress intensity factor, are shown in Figs. 38 through 51 for the various alloys and products. The crack propagation rates are given in terms of da/dN , where a is one-half the total crack length, and N is the number of cycles. The rates shown in the figures were determined by averaging the rates obtained for the multiple specimens of each sample, direction and surface condition. The data were not included in the average if cracks were not visible at all four "corners" of the notch by the time the total

crack length equalled 1.0 in. ($33\frac{1}{3}$ per cent of the gross area cracked).

In Figs. 38 through 51, curves have been drawn to fit the crack propagation data. For plots such as Fig. 36, a straight line relationship (proposed by Paris and Erdogan⁽⁹⁾ and others) provides a good fit. Anderson⁽¹⁰⁾ suggested that there might be a tailing off of the crack propagation curves at both the very low and very high rates. The data for 7178-T6510 extrusions, Figs. 49 and 50, indicate such a relationship.

For X7080-T7E41 plate, Figs. 38 and 39, neither specimen direction, nor light machining to remove the rolled surface of longitudinal specimens, affected the crack propagation behavior of the 1/2-in. thick plate. Similar rates were obtained for specimens from the 1/2-in. thick plate, and from the center of the 1-3/8-in. thick plate.

The 7178-T651 plate (Figs. 40 and 41), especially the 1/2-in. thick sample, was plagued with eccentric cracking. In several cases only one specimen of three had cracks visible at all four corners of the notch by the time the total crack length reached 1.0 in. For this alloy, machining to remove the rolled surface appears to decrease the resistance to crack propagation. In view of the crack eccentricities, there are not enough consistent differences to indicate a directional effect for either plate thickness.

In Fig. 42, the crack propagation curves for the longitudinal specimens from 1-3/8-in. plate are compared with curves previously reported⁽¹¹⁾ for 7075-T7351 and 7075-T651 specimens

from a similar product. The crack propagation rates for 7075-T7351 and X7080-T7E41 plate are consistently lower than those for 7075-T651 and 7178-T651 plate. At medium stress-intensity ranges, the 7075-T651 plate has some advantage over the 7178-T651 plate.

For the 11/16-in. thick 7075-T6510 extrusions, Fig. 43, crack propagation rates were higher for transverse specimens than for longitudinal specimens. However, machining to remove the extruded surface of the longitudinal specimens reduced their resistance to crack propagation to about the same level as that of the transverse specimens. Except at the lowest stress intensities, Fig. 44 does not indicate any effect of specimen location in the 3-1/2-in. thick bar. Also, the curves shown for the 11/16-in. thick extrusion and 1-3/8 in. plate fall within the results shown for the 3-1/2-in. thick extrusion.

It can be seen from Fig. 45 that machining to remove the extruded surface did not affect the propagation rate for the 11/16-in. thick 7075-T73510 extrusion, but that crack propagation rates were somewhat higher for transverse specimens than for longitudinal specimens. In Fig. 46, there is close agreement among the crack propagation rates determined for the longitudinal directions in the various 7075-T73510 products.

Except at the shorter crack lengths, crack propagation was generally faster for transverse X7080-T7E42 specimens than for longitudinal specimens (Fig. 47). Machining to remove the extruded surface of longitudinal specimens did not consistently affect the propagation rate. In Fig. 48, the propagation rate for the X7080-T7E42 specimen from the center of thickness of the

extruded bar was somewhat slower than the propagation rates for the surface specimens. Also, the propagation rates for both the 1-3/8 in. X7080-T7E41 plate and the 11/16-in. X7080-T7E42 extruded panel were slower than those of the rates determined with specimens from the surface or the center of thickness of the 3-1/2 in. X7080-T7E42 extruded bar.

The 7178-T6510 extrusions tended to crack eccentrically (as did the 7178-T651 plate), so the data for several specimens were excluded from the average. Neither the specimen direction nor the surface condition consistently affected the propagation rates for the 11/16-in. extrusions (Fig. 49). Fig. 50 shows that the two thicknesses of 7178-T6510 extrusions had comparable crack propagation rates. At the lower stress intensity factors their propagation rates were somewhat slower than the rate for the 7178-T651 plate.

The crack propagation rates for longitudinal specimens from the 3-1/2-in. thick extrusions are compared in Fig. 51. The ranking of the alloys and tempers with respect to rate of fatigue crack propagation is generally the same as for plate: 7075-T73510 has the slowest rate, X7080-T7E42 is next, followed by 7075-T6510 and 7178-T651. The advantage of 7075-T73510 over X7080-T7E42 in the extruded bar is somewhat greater than that which is shown for the corresponding plate samples. The 7178-T6510 curve has an average slope of about 0.25. The lines for the other alloys are less curved, and have slopes of about 0.37.

The fatigue crack propagation characteristics of the materials which have been tested in this contract may be summarized as follows:

1. For both extrusions and plate, crack propagation was faster for transverse specimens than for longitudinal specimens.

2. Neither machining to remove the extruded or rolled surfaces, nor taking specimens from the center of thickness of the thicker extrusions, consistently affected the crack propagation rates.

3. In most cases, similar crack propagation rates were obtained for the extrusions and the plate as well as for the two thicknesses of these products.

4. Except for the shorter cracks (low range of stress intensities) the plate and extrusion alloys would rate in the following order of decreasing resistance to fatigue crack propagation:

7075-T73-type
X7080-T7-type
7075-T6-type
7178-T6-type

5. The relation between ΔK , the range of stress intensity and da/dN , the rate of crack propagation, was close to linear on log-log plots for all except the 7178-T6-type samples. The slopes for the data were about 0.37, instead of 0.25 as suggested by Paris in his relationship $\frac{da}{dN} = \frac{(\Delta K)^4}{C}$.

D. Corrosion Characteristics

1. Exfoliation and Stress Corrosion (Conventional Tests)

a. Status of Tests

All of the accelerated corrosion tests have been

completed. All atmospheric tests are in progress, but the results are still too preliminary to be conclusive.

The results of the accelerated exfoliation tests of the plate and extruded shapes were reported in the Fourth and Seventh Quarterly Technical Management Reports, respectively^(4,7).

The results of the accelerated stress-corrosion tests of the plate and extruded shapes were reported in the Fifth and Sixth Quarterly Technical Management Reports^(5,6); those for extrusions were contained, for the most part in the Seventh Quarterly Technical Management Report,⁽⁷⁾ and are completed in this report.

b. Test Results

The data for the accelerated and the atmospheric tests which were in progress during the seventh quarter were reported in the Seventh Quarterly Technical Management Report.⁽⁷⁾ Some additional long-transverse specimens from between the ribs of the 11/16x16-in. extruded panels completed 84 days of exposure to alternate immersion in a 3-1/2 per cent NaCl solution during the eighth quarter, and the results are shown in Table III. The status of the other tests did not change during the eighth quarter, and the other status tables do not need to be reproduced for this report.

The per cent reduction in tensile strength by corrosion in alternate immersion was determined for longitudinal and long-transverse specimens from the extruded shapes during this quarter. These data are reported in Table IV.

c. Discussion of Stress-Corrosion Results

(1) 1 1/16x16-in. and 3-1/2x7-1/2 in. Extruded Shapes

(a) Longitudinal Direction (3-1/2x7-1/2 in. Extruded Bars Only)

No longitudinal specimen has failed, thereby confirming the high resistance to stress-corrosion cracking which is expected in this direction of all alloys and tempers.

The per cent reduction in tensile strength after 182 days exposure to alternate immersion (Table IV) indicates the relative resistance to general corrosive attack. Alloy X7080-T7E42 was the least affected, followed by 7075-T73510 and then 7075-T6510 and 7178-T6510, which were similar. This general order is in agreement with test results on other items of these alloys-tempers. The reductions in strength of the unstressed and the stressed specimens was generally similar. The most divergent case was the 7178-T6510, for which the stressed specimens showed double the loss in strength of the unstressed specimens. This degree of difference for 7178-T6510, however, is not unusual.

(b) Long-Transverse Direction

For both extruded shapes, failures of the long-transverse specimens in the accelerated and atmospheric tests have occurred only for the 7075-T6510 and 7178-T6510 samples.⁽⁷⁾ While these two items are known to be the most susceptible of the four alloy-tempers evaluated, most of these specimens did not contain a true long-transverse grain structure. The 3-1/2x7-1/2 in. bar had a more or less equi-axed grain structure which would more correctly be described as simply transverse (similar to the grain structure

in round and square shapes). In the 11/16x16-in. panel, the long-transverse specimens centered under an outstanding rib had a grain structure on an angle to the specimen axis, rather than parallel to it, because of metal movement into the rib during the extrusion process. It is significant that even with these less favorable grain structures, 7075-T73510 and X7080-T7E42 were still resistant to cracking.

The only true long-transverse specimens were the 0.125 in. diameter specimens centered between the outstanding ribs of the 11/16x16-in. panels (Table III). Failure in this case (verified as stress-corrosion cracking by microscopic examination) occurred only for 7178-T6510. Even here a moderately high degree of resistance was indicated, with all three specimens failing in 56 to 67 days, as compared with failures in 10 to 13 days when the same size specimens were positioned directly under a rib.

The four alloy-temper combinations tested in this project are listed below in relative order of decreasing resistance to stress-corrosion cracking of the long-transverse specimens. This order agrees with Alcoa experience with other extruded samples.

11/16x16-in. Extruded Ribbed Panels

7075-T73510 and X7080-T7E42 (very high resistance)
7075-T6510 (high resistance)
7178-T6510 (medium resistance)

3-1/2x7-1/2-in. Extruded Bar (Equi-axed Grain Structure)

7075-T73510 and X7080-T7E42 (very high resistance)
7075-T6510 and 7178-T6510 (low resistance)

The per cent reductions in tensile strength of the various

long-transverse specimens exposed to alternate immersion are given in Table IV. The results for unstressed specimens show the same trend as was cited above for longitudinal specimens; X7080-T7E42 is the most resistant to general corrosion, followed by 7075-T73510, then 7075-T6510, with 7178-T6510 the least resistant. The reductions in tensile strength of stressed specimens were not excessively high as compared with the corresponding unstressed specimens, except for the specimens from the 3-1/2x7-1/2-in. X7080-T7E42 bar (Sample No. 340731), where the reductions for stressed specimens were four times the reductions for unstressed specimens. Representative unstressed and stressed specimens of this sample have been submitted for microscopic examination, to determine whether the relatively large reduction in tensile strength of the stressed specimens was merely the result of deeper corrosive attack, or was caused by incipient stress-corrosion cracks.

(c) Short-Transverse Direction (3-1/2x7-1/2-in. Extruded Bars Only)

The results of the tests of the short-transverse specimens were discussed in the Seventh Quarterly Technical Management Report⁽⁷⁾ and showed 7075-T73510 to be the most resistant material (no failures at 75 or 50 per cent of the yield strength), followed by X7080-T7E42 (failure at 75 per cent of the yield strength, no failure at 50 per cent of the yield strength and below), and then 7075 and 7178-T6510 (complete failure at 50 and 25 per cent of the yield strength, with 1 of 3 specimens failing at 15 per cent of the yield strength).

Some of the stressed specimens which survived 84 days of exposure to alternate immersion in a 3-1/2 per cent NaCl solution showed high losses in tensile strength. These specimens were examined microscopically. Examination of the 7075-T73510 specimens which had been stressed to 75 per cent of the yield strength showed no evidence of incipient stress-corrosion cracking and verified that these specimens were resistant to stress-corrosion cracking. On the other hand, intergranular cracks were found in both the 7075-T6510 and 7178-T6510 specimens which had been stressed to 15 per cent of the yield stress, confirming the susceptibility to stress-corrosion cracking that had already been shown by a single failure for each of these two samples.

2. Stress Corrosion With A Fracture Mechanics Approach

Tests of bolt-loaded specimens (shown in Fig. 30 of Ref. 6) from each of the 3-1/2x7-1/2 in. extruded bars were completed this quarter. Specimens from each sample were loaded to various stress intensity levels (usually 100, 90 and 80 per cent of the ambient K_{Ic} value) and exposed by either total or alternate immersion in 3-1/2 per cent NaCl solution. At least one specimen from each sample was precracked in direct tension, rather than by fatigue, and since the load was not removed after precracking, the initial K_{I1} value should have been reasonably close to K_{Ic} . The initial crack lengths for specimens precracked in fatigue were based on measurements made on the surfaces of the specimens. Since the crack fronts through the thicknesses of the specimens were not perfectly straight, the initial crack lengths,

loads and K_{I1} values for the fatigue-cracked specimens are estimated values. Several of these specimens were discontinued after about 1000 hours of exposure, but the majority of the specimens were exposed for 2500 hours.

The results of these tests are summarized in Table V and plots of crack growth versus time are shown in Figs. 52 through 55. As shown in the figures, specimens from alloys 7075 and 7178 in the T6510 temper experienced considerable crack growth; specimens from X7080-T7E42 experienced moderate crack growth and specimens from 7075-T73510 experienced negligible crack growth. For alloys in which cracks grew, the specimens loaded to 100 per cent K_{Ic} experienced more crack growth than those with lower applied K_{I1} values.

Initially, crack growth in the susceptible alloys seems to have been more rapid in alternate immersion tests than in total immersion tests. After 2500 hours exposure the residual stress intensity factors for the susceptible alloys, shown in Table V, approached the same level regardless of the type of test (alternate or total immersion) or applied stress intensity (K_{I1}). Except for one specimen, the residual stress intensities for 7075-T6510 range from 13,000 to 13,500 $\text{psi}\sqrt{\text{in.}}$, and the residual stress intensities for 7178-T6510 range from 8600 to 10,800 $\text{psi}\sqrt{\text{in.}}$ For both samples, there is little difference between the residual stress intensities after 800 and 2500 hours in the alternate immersion tests, even though the cracks continued to grow (see Figs. 52 and 55) at a slow rate.

Specimens from the 7075-T73510 sample experienced

negligible crack growth. One must thus conclude that this alloy is not susceptible to stress-corrosion crack growth even though the residual stress intensities are lower than the estimated initial values. This apparent decay in stress intensity could be due to creep or stress relaxation in the screw threads or other highly stressed regions in the specimen, or the actual initial stress intensities may have been lower than the estimated values.

Specimens from the X7080-T7E42 sample experienced some crack growth, but some of the apparent decay in stress intensity may be due to the reasons mentioned above for the 7075-T73510 tests. In any event, there is considerable variability in residual stress intensity values, which may indicate that 2500 hours exposure is not long enough to allow specimens of this particular material to approach a stable condition.

The data for the tests of ring-loaded specimens are summarized in Table VI. (This phase of the testing is still in progress.) It appears that stress-corrosion cracks propagate faster in the alternate immersion test than in the total immersion test. One specimen of 7075-T6510 in alternate immersion failed in about the same time as two other specimens with higher applied stress intensities (K_{Ii}) in total immersion, and one specimen of 7178-T6510 in alternate immersion failed in about one-third the time of an identical specimen (same K_{Ii}) in total immersion.

The data for ring-loaded specimens of 7075-T6510 and 7175-T6510 seem to be approaching the same stable stress intensity

level (K_{Isc}) as the bolt-loaded specimens of the same alloys. The data for the samples of X7080-T7E42 and 7075-T73510 are not as clear-cut, but it appears that both samples are relatively resistant to stress corrosion.

A more thorough analysis of these data will be presented in the final report, when metallographic examinations and the long-time tests of ring-loaded specimens will be complete. It seems evident at this point that the stress-corrosion data which have been developed with a fracture-mechanics approach rate these samples in the same order as stress-corrosion data which have been developed with smooth tensile specimens. The four samples rank as follows, in order of decreasing resistance to stress-corrosion crack growth:

7075-T73510
X7080-T7E41
7075-T6510
7178-T6510

V. Program for Next Quarter.

Planned effort during the next quarter will consist of completing the tests which are in progress, analyzing the data which have been generated, and preparing the final report.

1. The axial-stress fatigue tests of notched ($K_t = 3$) specimens from the 3-1/2x7-1/2-in. extruded bar samples will be completed.
2. The axial-stress fatigue tests of notched ($K_t = 12$) specimens from the extruded bar samples will be completed. S-N curves and modified Goodman diagrams will be prepared.
3. The stress-corrosion specimens from the 1/2-in. and 1-3/8-in. thick plate samples will complete one year of exposure

to the seacoast atmosphere at Point Judith, Rhode Island, on March 31, 1969.

4. The stress-corrosion specimens from the 11/16x16-in. extruded panels and the 3-1/2x7-1/2-in. extruded bars will complete one year of exposure to the inland industrial atmosphere at New Kensington, Pennsylvania, on June 14, 1969. Specimens from these samples will complete one year of exposure to the seacoast atmosphere at Point Judith, Rhode Island, on June 2, 1969.

5. The tests to determine stress-corrosion resistance by a fracture-mechanics approach will be concluded. Tests of ring-loaded specimens and metallographic examinations will be finished.

6. The final report will be prepared.

A milestone chart indicating progress on the contract is shown in Fig. 56.

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11. J. G. Kaufman, G. E. Nordmark and B. W. Lifka, "Fracture Toughness, Fatigue and Corrosion Characteristics of 7075-T651, 7075-T7351 and 7079-T651 Aluminum Alloys," Technical Report AFML-TR-65-170, May 1965.

VI. Tables and Figures.

TABLE I

TENSILE PROPERTIES OF ALUMINUM ALLOY PLATE AND EXTRUDED SHAPES EVALUATED ON F33615-67-C-1521
(Tentative)

Product	Alloy and Temper	AVL Sample Number	Thickness, or Size and Shape, in.	LONGITUDINAL		LONG-TRANSVERSE		SHORT-TRANSVERSE	
				Tensile Strength, psi	Yield Strength, psi	Elongation in 4D, %	Tensile Strength, psi	Yield Strength, psi	Elongation in 4D, %
Plate	X7030-T7261	343260	1/2	68 200	58 900	16.5	67 600	56 800	15.0
		343259	1-3/8 Minimum*	67 900 NOT ESTABLISHED	60 200 ESTABLISHED FOR THIS PRODUCT	14.5	68 300	59 600	12.5
Extrusion	7178-T651	340457	1/2	86 800	83 400	14.5	88 500	78 800	11.0
		340450	Minimum* 1-3/8 Minimum*	92 500 NOT ESTABLISHED	81 900 ESTABLISHED FOR THIS PRODUCT	9.0	84 000	73 000	4.0
	7075-T6510	340637	11/16x16 panel	90 400	82 400	12.5	87 000	78 700	13.6
		340619	Minimum* 3-1/2x7-1/2 bar	81 000 75 700	72 000 70 000	7.0 10.9	77 300	66 700	10.5
Extrusion	7075-T73510	340639	11/16x16 panel	75 700	65 000	12.9	73 100	62 400	10.0
		340620	Minimum* 3-1/2x7-1/2 bar	70 000 73 700	61 000 63 800	7.0 12.6	67 400	56 800	9.5
	X7080-T7262	340730	11/16x16 panel	72 400	63 800	14.6	70 900	60 200	11.6
		340732	Minimum* 3-1/2x7-1/2 bar	72 000 NOT ESTABLISHED	64 000 ESTABLISHED FOR THIS PRODUCT	13.0	68 000	59 100	11.5
Extrusion	7178-T6510	340616	11/16x16 panel	84 400	87 200	11.0	91 100	82 900	10.7
		340635	Minimum* 3-1/2x7-1/2 bar	87 000 89 000	78 000 80 700	5.0 9.2	77 000	67 900	4.5
Extrusion	7178-T6510	340616	11/16x16 panel	84 400	87 200	11.0	91 100	82 900	10.7
		340635	Minimum* 3-1/2x7-1/2 bar	87 000 89 000	78 000 80 700	5.0 9.2	77 000	67 900	4.5

* At locations corresponding to specification test locations: Plate - $t/2$, Extruded panel - $t/2$, $W/4$ (L); $t/2$, $W/2$ (LT); Extruded bar - $t/4$, $W/4$ (L); $t/2$, $W/2$ (LT, ST)
t - thickness, W - width.

* Not established at this time.

* Standards for Aluminum Mill Products, Aluminum Association, 1967.

** 0.2 per cent offset.

TABLE II

CYCLES REQUIRED TO INITIATE FATIGUE CRACKS IN CENTER-NOTCHED SPECIMENS

Net Stress = 3300 psi minimum to 9900 psi maximum

P33615-67-C-1521
(Tentative)

Alloy	Temper	Product	ARL Sample Number	Nominal Specimen Thickness, in.	Surface Condition or Location	Direc- tion	No. of Tests	Number of Cycles to Initiate Crack		
7075	T6510	Extruded Panel	340637	11/16	Extruded	(a) L	3	82,300	95,200	116,700
					Machined	L	2	120,700	154,400	
					Extruded	LT	3	98,100	113,000	225,200
7075	T6510	Extruded Bar	340619	3/4	Surface T/4	L	2	113,500	128,200	
						L	1	148,000		
7075	T73510	Extruded Panel	340639	11/16	Extruded	(a) L	3	62,300	68,700	78,200
					Machined	L	2	56,400	106,500	
					Extruded	LT	3	71,100	82,200	86,900
7075	T73510	Extruded Bar	340620	3/4	Surface T/4	L	2	91,100	139,000	
						L	1	97,100		
X7080	T7E42	Extruded Panel	340730	11/16	Extruded	(a) L	3	71,900	110,600	116,000
					Machined	L	2	79,000	85,000	
					Extruded	LT	3	55,600	56,700	69,400
X7080	T7E42	Extruded Bar	340732	3/4	Surface T/4	L	2	97,700	111,000	
						L	1	91,400		
X7080	T7E41	1/2-in. Plate	343260	1/2	Rolled	(a) L	4	80,700	105,100	113,300
					Machined	L	2	71,000	116,400	164,000
					Rolled	LT	3	82,200	90,300	107,500
X7080	T7E41	1-3/8-in. Plate	343259	3/4	T/2	L	3	51,600	80,300	86,600
					T/2	LT	3	72,900	75,600	83,700
7178	T6510	Extruded Panel	340616	11/16	Extruded	(a) L	3	95,000	98,600	137,600
					Machined	L	2	145,000	200,100	
					Extruded	LT	3	115,900	124,600	235,100
7178	T6510	Extruded Bar	340635	3/4	Surface T/4	L	2	121,700	155,700	
						L	1	137,800		
7178	T651	1/2-in. Plate	340457	1/2	Rolled	L	3	312,300(d)	3,874,100(d,c)	
								11,954,900(d)		
7178	T651	1-3/8-in. Plate	340450	3/4	Machined(a)	L	2	398,100	1,570,400(d)	
					Rolled	LT	3	450,700	6,008,600(d)	
									11,252,000(b)	
7178	T651	1-3/8-in. Plate	340450	3/4	T/2	L	3	107,600	167,900	208,800
					T/2	LT	3	147,100	209,100	1,149,400

NOTES: (a) 0.020 machined from surface.
 (b) Complete fracture.
 (c) Failed in grip end.
 (d) Hole oversize.

TABLE III

STATUS OF ADDITIONAL LONG-TRANSVERSE STRESS CORROSION TESTS ON THE 11/16-IN. EXTRUDED PANEL (1)

P33615-67-C-1521
(Tentative)

Alloy and Temper	Sample Number	Environment:	Specimen Number and Days to Failure (2)					
			3.5% NaCl Alt. Immersion (84 Days)		Pt. Judith Atmos. (4 Years)		New Kensington Atmos (4 Years)	
			Date Started:		October 16, 1968		December 30, 1968	
			No.	Days	No.	Days	No.	Days
7075-T6510	340637		CT5W	OK 84	CT10W		CT15W	
			CT6W	OK 84	CT11W		CT16W	
			CT7W	OK 84	CT12W		CT17W	
7075-T73510	340639		CT5W	OK 84	CT10W		CT15W	
			CT6W	OK 84	CT11W		CT16W	
			CT7W	OK 84	CT12W		CT17W	
X7080-T7E42	340730		CT5W	OK 84	CT10W		CT15W	
			CT6W	OK 84	CT11W		CT16W	
			CT7W	OK 84	CT12W		CT17W	
7178-T6510	340616		CT5W	67	CT10W		CT15W	
			CT6W	67	CT11W		CT16W	
			CT7W	56	CT12W		CT17W	

NOTES: (1) Specimens from between the ribs. Triplicate tensile specimens stressed in direct tension to 75 per cent of the respective yield strength. Duplicate unstressed specimens also exposed to each environment. Specimens were 0.125 in. in diameter.

(2) No entry in the "days" column means specimen has not failed and is still in test.

TABLE IV

REDUCTION IN TENSILE STRENGTH BY CORROSION OF 3-1/2 AND 11/16 IN. EXTRUSIONS (1)
 F33615-67-C-1521
 (Tentative)

		3-1/2x7-1/2 in. Extruded Bar			
Alloy and Temper	Sample Number	Longitudinal		Long-Transverse	
		0.437 in. Diameter	0.437 in. Diameter	0.437 in. Diameter	0.437 in. Diameter
		Unstressed	Stressed	Unstressed	Stressed
7075-T6510	340619	8	11	10	*
7075-T73510	340620	3	4	11	9
X7080-T7E42	340731	1	1	3(2)	12(2)
7178-T6510	340635	8	16	17	*

		11/16x16 in. Extruded Ribbed Panel			
Alloy and Temper	Sample Number	Long-Transverse		Between Ribs	
		Centered Under Outstanding Rib	0.125 in. Diameter	0.125 in. Diameter	0.125 in. Diameter
		Unstressed	Stressed	Unstressed	Stressed
7075-T6510	340637	8	*	18	6
7075-T73510	340639	6	13	6	8
X7080-T7E42	340730	3	3	2	4
7178-T6510	340616	9	*	17	12

* No value since all three specimens failed by stress-corrosion cracking.

- NOTES: (1) Duplicate unstressed and triplicate specimens stressed to 75% of the respective yield strength were exposed to alternate immersion in 3.5% NaCl solution. The 0.437 in. diameter specimens were exposed for 182 days, and the 0.125 in. diameter specimens were exposed for 84 days.
- (2) These specimens have been submitted for microscopic examination to determine whether the increased loss in stressed specimens was because of deeper corrosive attack or incipient stress-corrosion cracking.

TABLE V

STRESS-CORROSION FRACTURE TOUGHNESS DATA FOR SHORT-TRANSVERSE FOUR-LOADED SPECIMENS OF SOME HIGH STRENGTH ALUMINUM ALLOY 3-1/2x7-1/2 IN. EXTRUDED BARS EXPOSED TO 3-1/8% NaCl SOLUTION
F33615-67-C-1521
(tentative)

Alloy and Temper	Sample Number	Type of Test	Exposure Period, hrs.	Method of Pre-cracking	Initial Values			Residual Values		
					Crack Length, in.	Load, lb	K_{Ic} , psi $\sqrt{\text{in.}}$	Crack Length, in.	Load, lb	K_{Ic} , psi $\sqrt{\text{in.}}$
7075-T6510	340619	AI	800	Tension	1.015	2760	19 200	1.555	560	13 000
			800	Fatigue	0.975	2340	15 300	1.200	1410	13 500
		TI	2500	Fatigue	0.950	2740	17 300	1.430	792	13 000
			340	Fatigue	1.000	2500	17 500	1.090	2370	17 100
7075-T73510	340620	AI	1000	Fatigue	0.950	2680	18 200	1.090	1810	14 400
			2500	Tension	1.060	2580	19 200	1.500	410	8 100
		TI	2500	Fatigue	1.005	2530	17 300	1.396	900	13 500
			2500	Fatigue	1.010	2220	15 300	1.420	813	13 000
X7080-T7202	340732	AI	2500	Tension	0.965	3200	20 600	0.965	2950	19 000
			2500	Fatigue	0.990	2490	16 600	1.009	2050	14 100
		TI	340	Fatigue	0.940	3180	19 800	0.950	2850	18 000
			1000	Fatigue	0.950	3120	19 700	0.980	2670	17 500
7078-T6510	340635	AI	2500	Fatigue	0.985	2810	18 600	1.004	2400	16 400
			800	Fatigue	0.980	2820	18 600	0.975	2410	16 000
		TI	2500	Tension	1.120	2750	23 200	1.386	1340	20 100
			2500	Fatigue	0.990	3130	20 900	1.082	2300	17 800
7078-T6510	340635	AI	2500	Fatigue	0.975	3190	20 900	1.032	2320	18 200
			2500	Fatigue	0.985	2800	18 600	1.118	1855	15 200
		TI	800	Tension	1.065	1920	14 400	1.485	526	10 000
			800	Fatigue	0.965	1790	11 600	1.125	945	8 600
7078-T6510	340635	TI	2500	Fatigue	0.975	1990	13 000	1.175	945	8 600
			2500	Tension	1.060	1940	14 400	1.580	350	8 700
			2500	Fatigue	0.995	1930	13 000	1.330	852	10 800

NOTE: (1) Data shown are for single tests.

(2) AI Alternate Immersion; TI - Total Immersion

(3) Alternate immersion cycles were continuous; 10 minutes in and 50 minutes out of solution.

TABLE VI

STRESS CORROSION FRACTURE TOUGHNESS DATA FOR SHORT-TRANSVERSE RING-LOADED SPECIMENS OF SOME HIGH STRENGTH ALUMINUM ALLOY 3-1/2X7-1/2 IN. EXTRUDED BARS EXPOSED IN 3-1/2% NaCl SOLUTION
F33615-67-C-1921
(tentative)

Alloy and Temper	Sample Number	Type of Test	Number of Cycles	Initial Values			Values at Rupture			Time to Rupture, hrs.
				Crack Length, in.	Load, lb	K _{II} , psi in.	Crack Length, in.	Load, lb	K _{II} , psi in.	
				Measured	Calculated		Measured	Calculated		
7075-T6510	340619	TI	---	0.955	1.041	19 500	--	1.173	2440	318
				0.950	0.977	18 400	1.10	1.128	2550	260
				1.000	0.986	15 100	1.157	1.167	2030	310
7075-T73510	340620	TI	---	0.975	0.953	12 900	1.219	1.192	1930	840
				0.965	0.977	19 800	0.990	0.981	3010	340*
				0.990	1.033	22 200	1.168	1.233†	2730	1010
7075-T6510	340635	TI	---	1.000	0.994	13 000	1.160	1.157	1710	340
				1.000	0.996	13 000	1.122	1.133	1770	182
				0.990	0.990	11 500	1.240	1.254	1830	264
7075-T6510	340635	AI	62	0.990	0.977	10 000	1.200	1.240	1420	480

NOTE: (1) AI - Alternate Immersion; TI - Total Immersion

(2) Alternate immersion cycles were accomplished manually during working hours. Specimens were submerged overnight and on weekends.

(3) Crack lengths were measured on the surfaces of the specimens. Calculated crack lengths were obtained with a clip gage and compliance calibration data.

(4) Stress intensities K_{II} and K_I are based on calculated crack lengths.

* This test was discontinued after 340 hours exposure.

† Calculated crack length may be incorrect because of creep in the specimen. K_{II} is based on measured crack length.

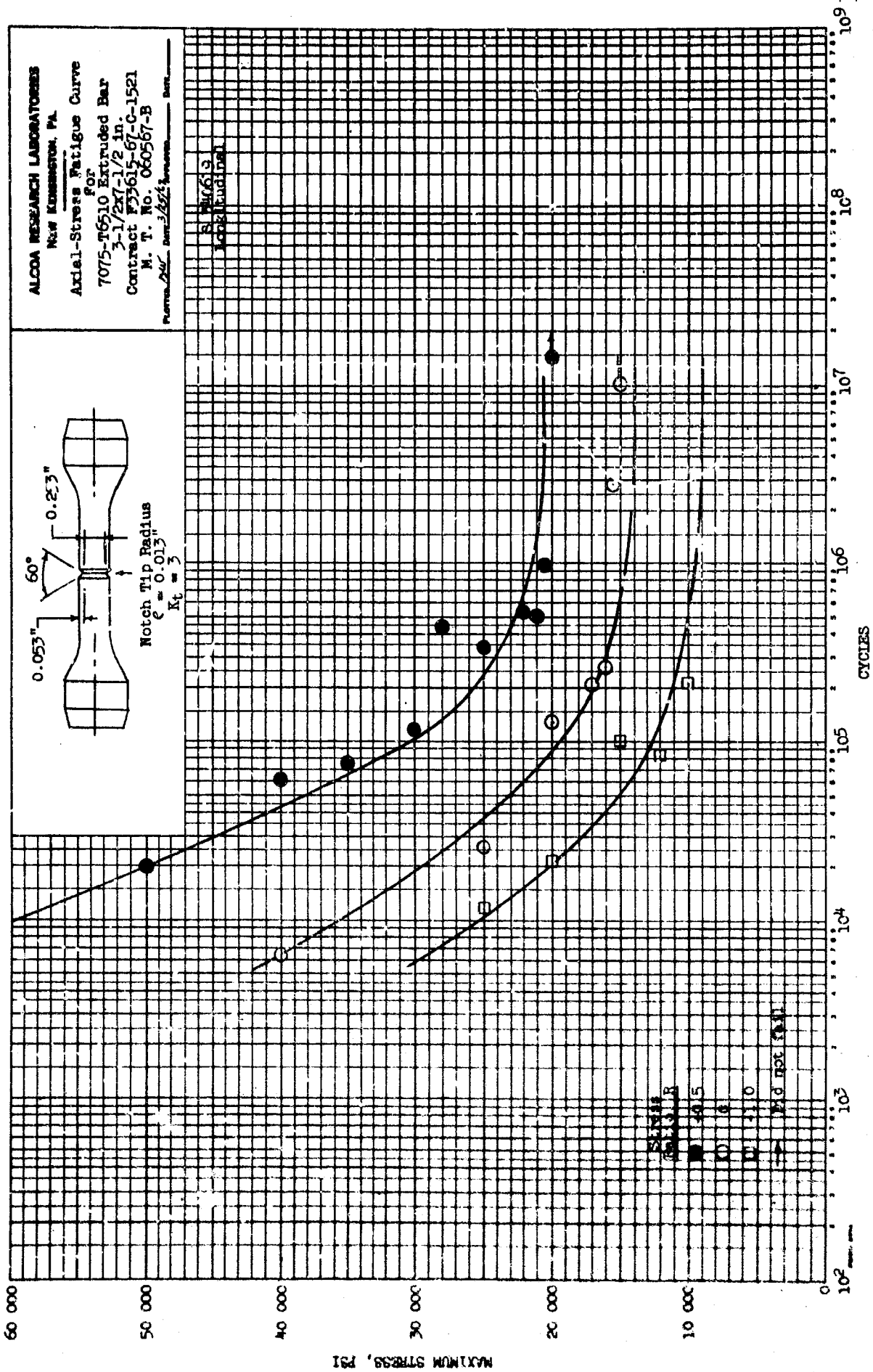


Fig. 1

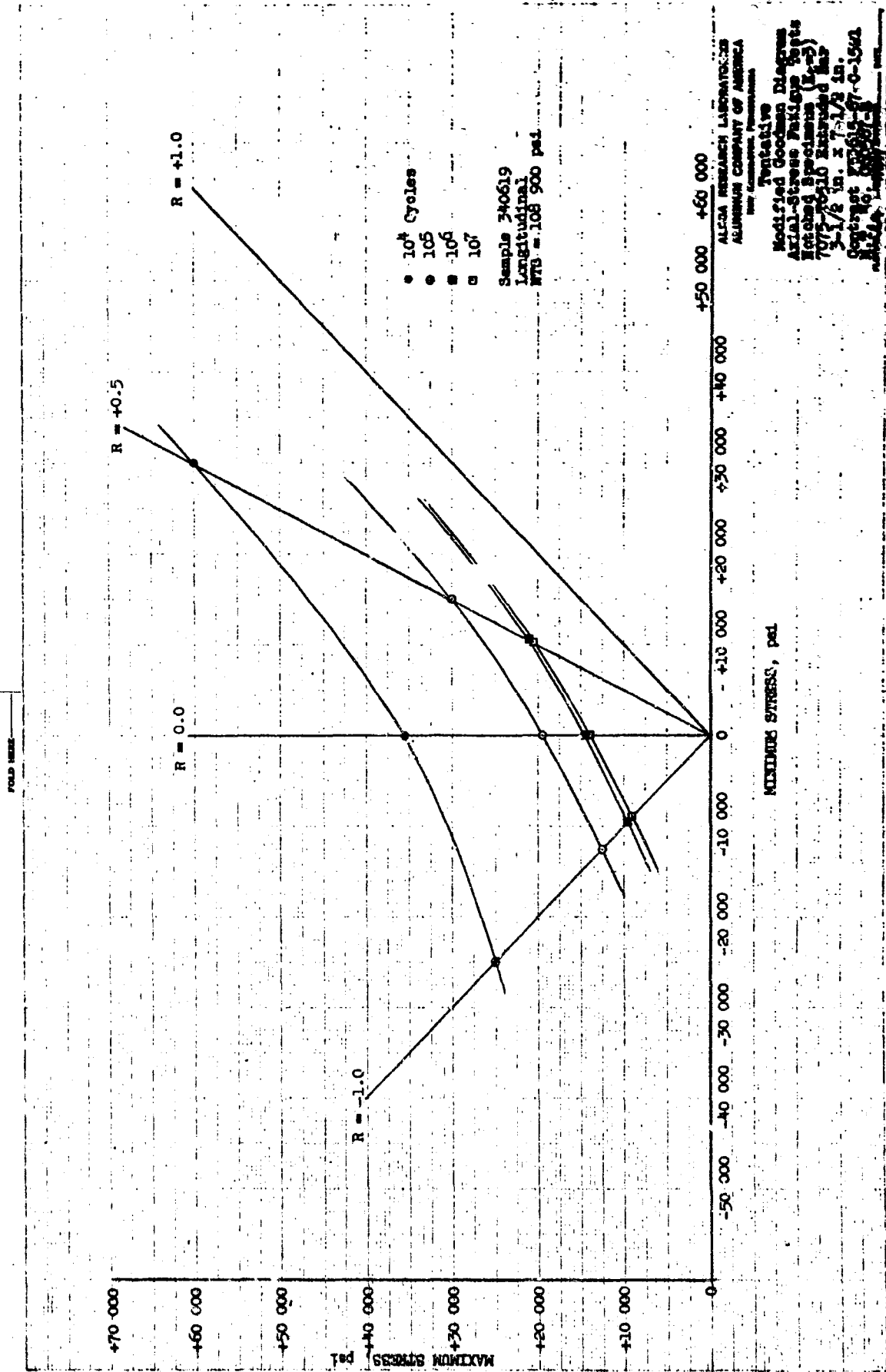


Fig. 2

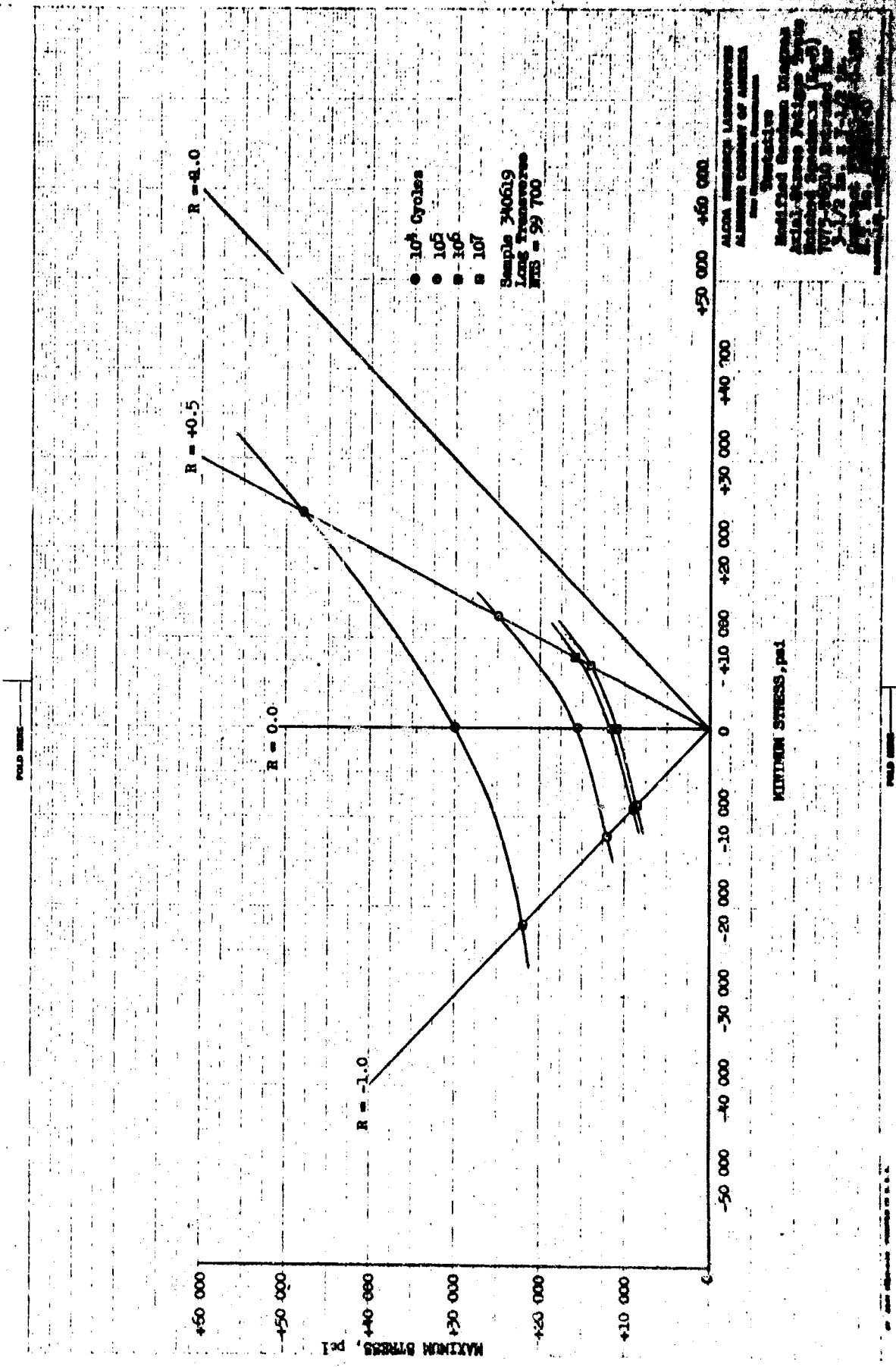


Fig. 4

Axial Stress Fatigue Curves
For
7075-T6510 Extruded Bar
3-1/2X7-1/2 in.
Contract F3615-67-C-1521
A. T. No. 060567-B

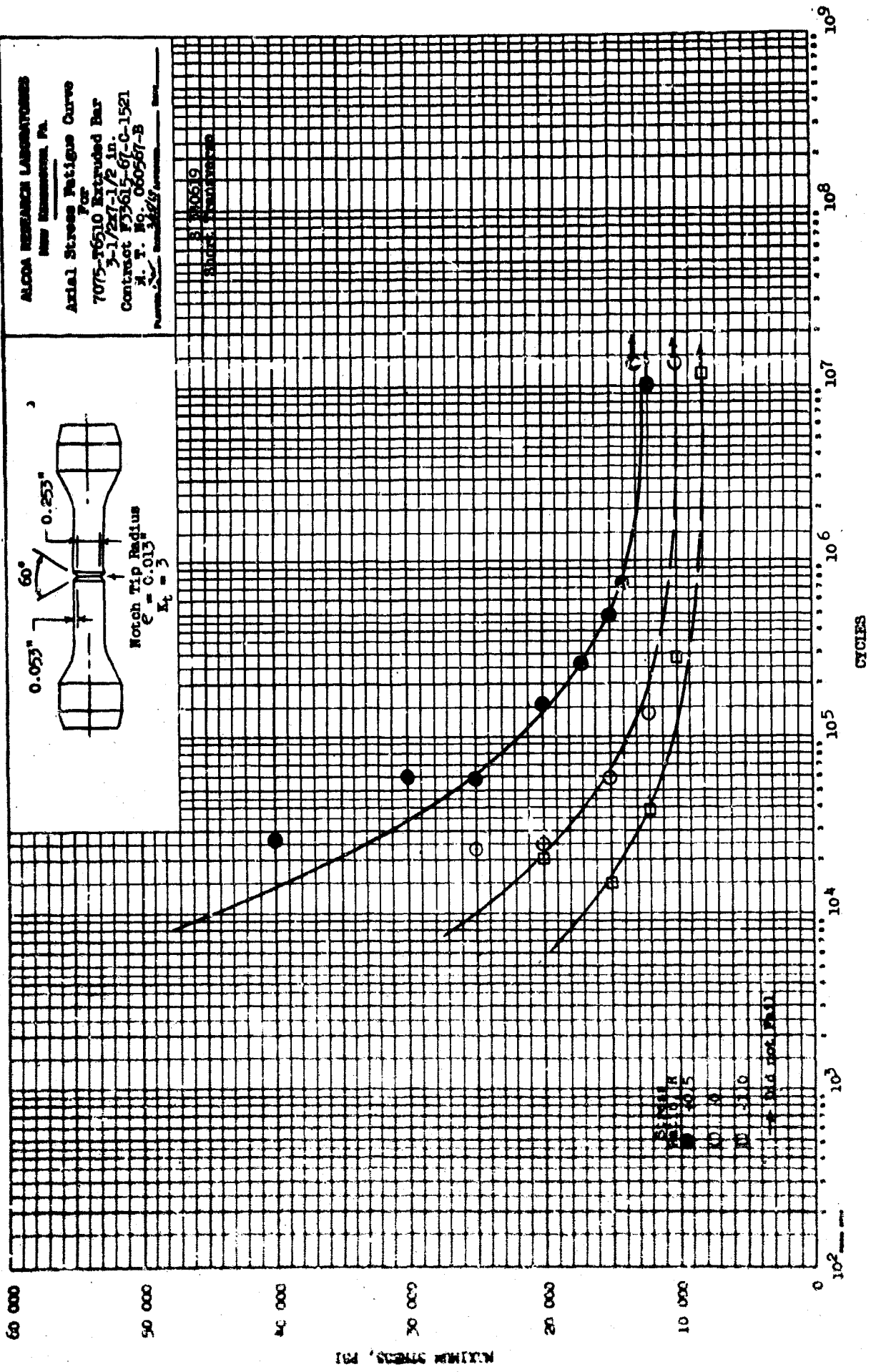
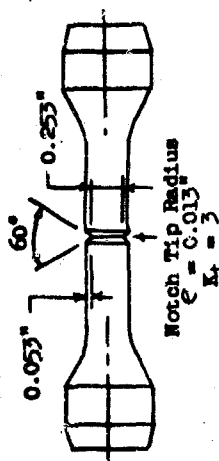


Fig. 5

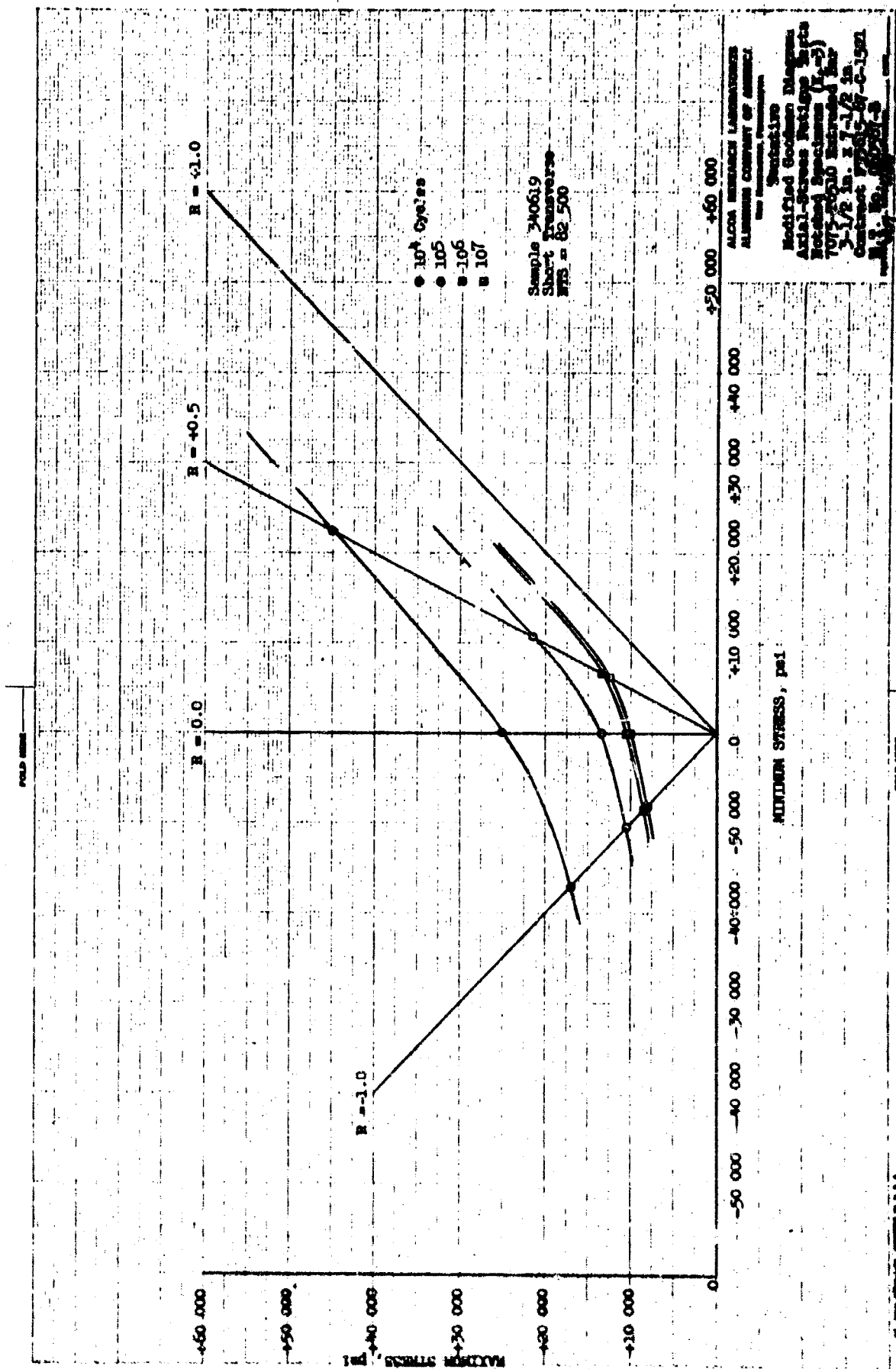


Fig. 6

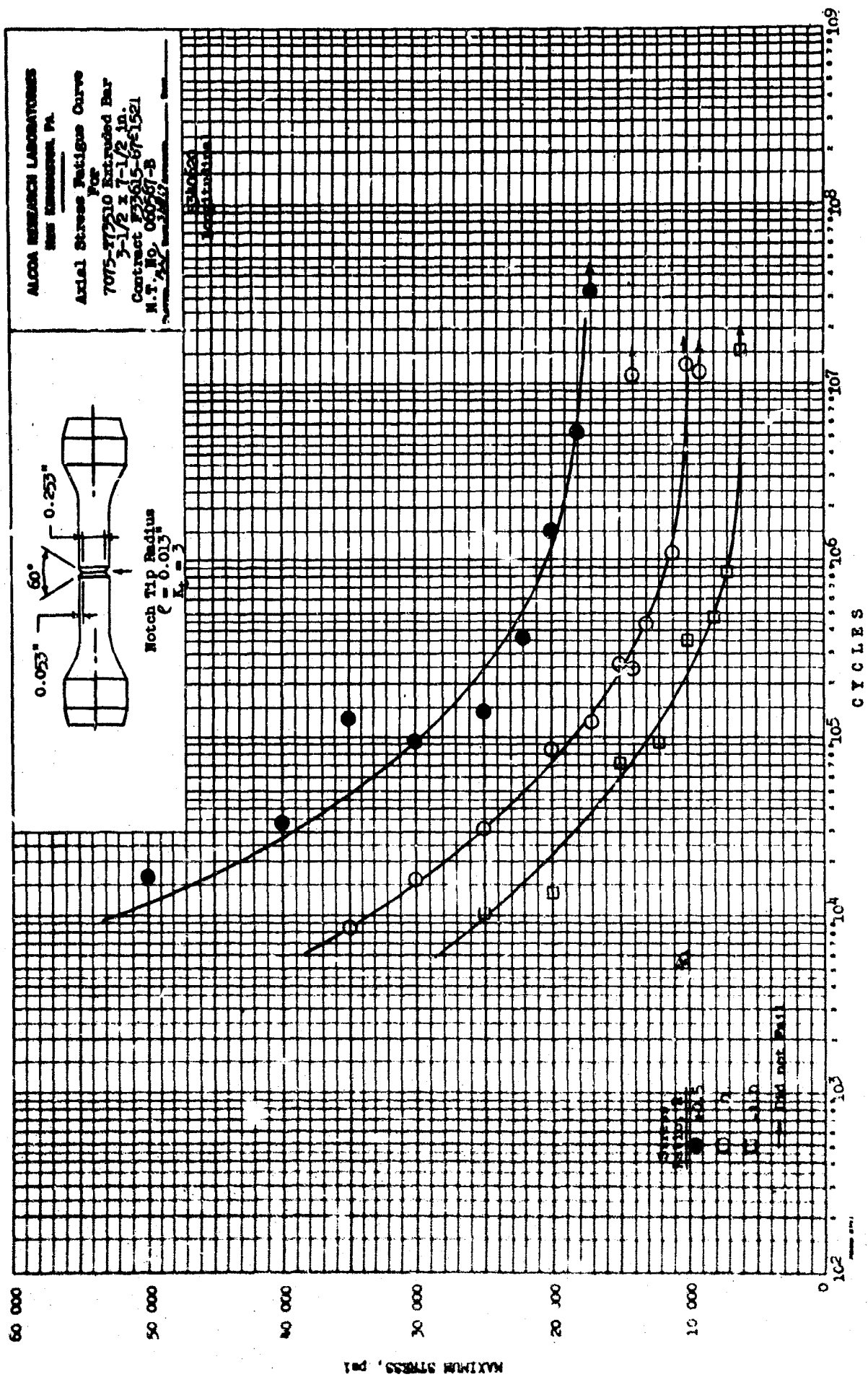


Fig. 7.

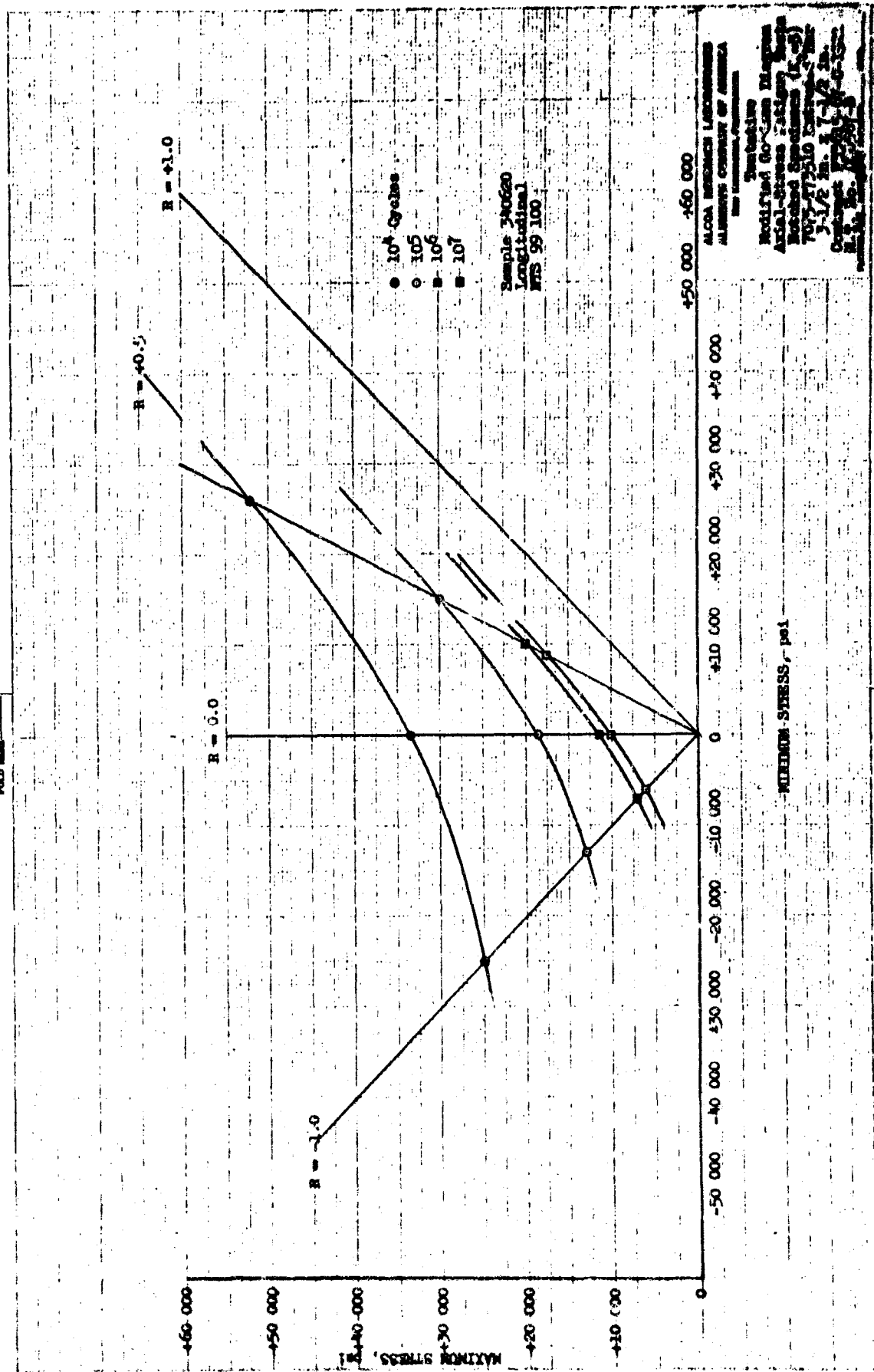
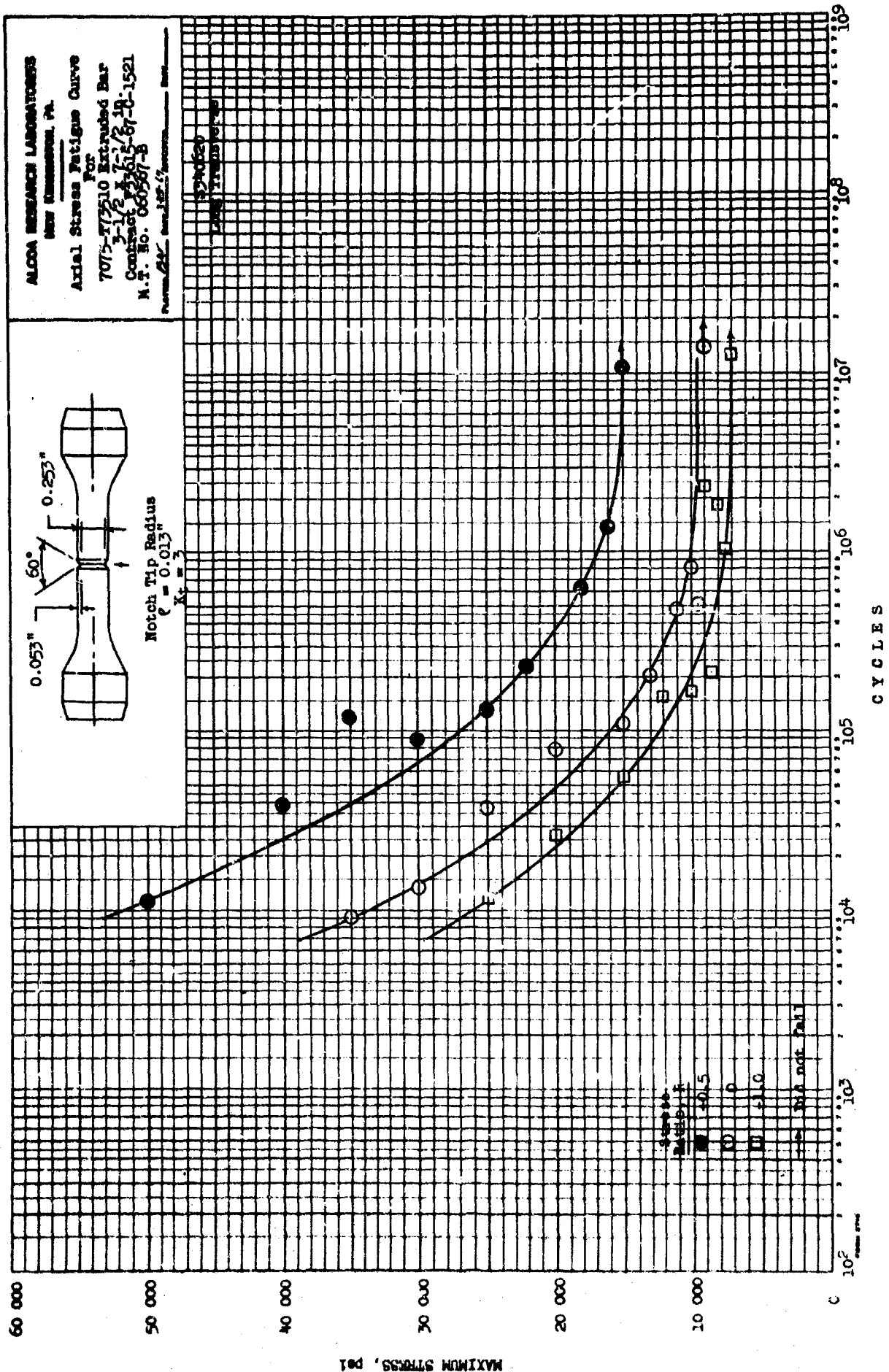


Fig. 8



MAXIMUM STRESS, PSI

Fig. 9

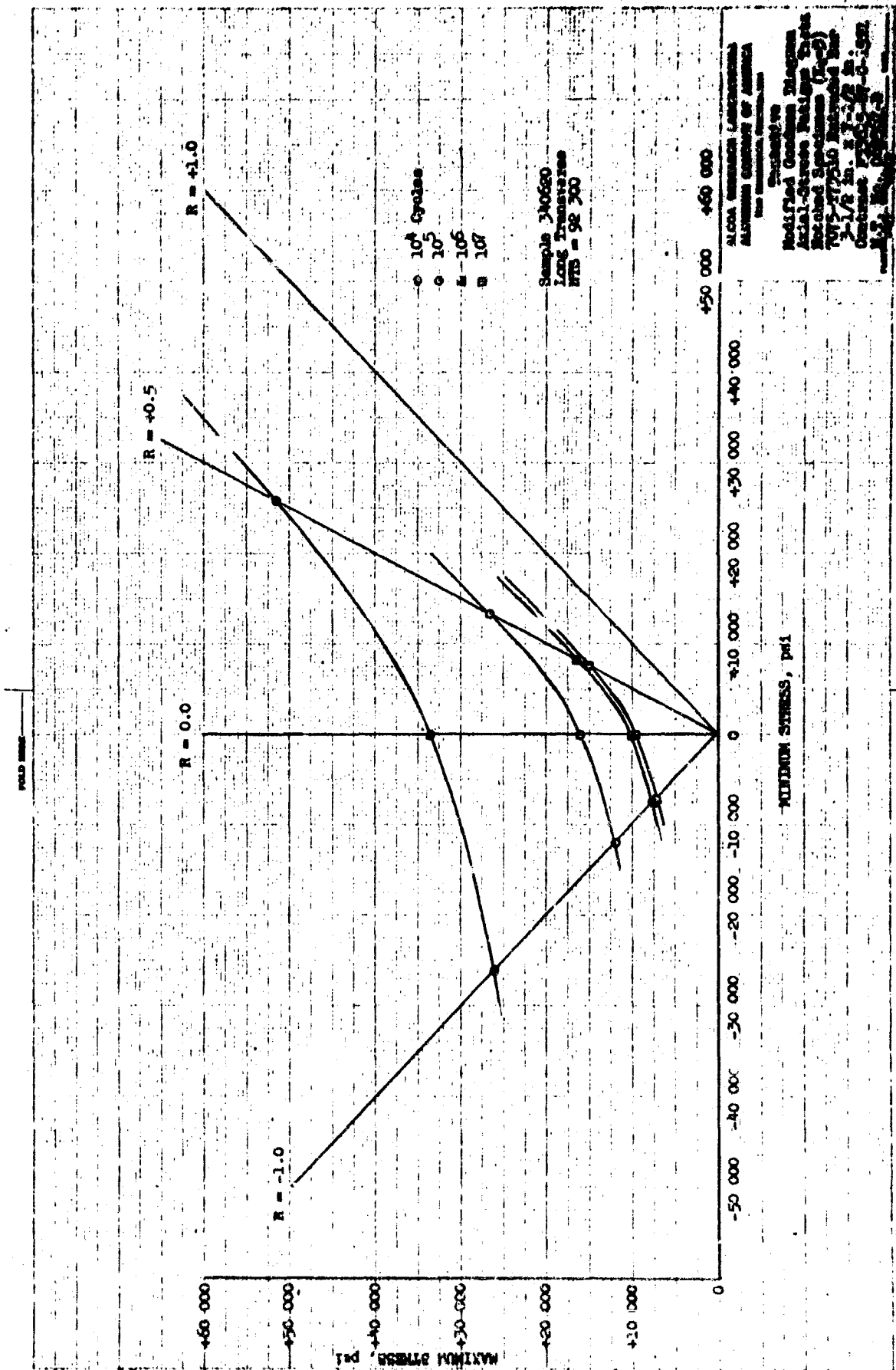


Fig. 10

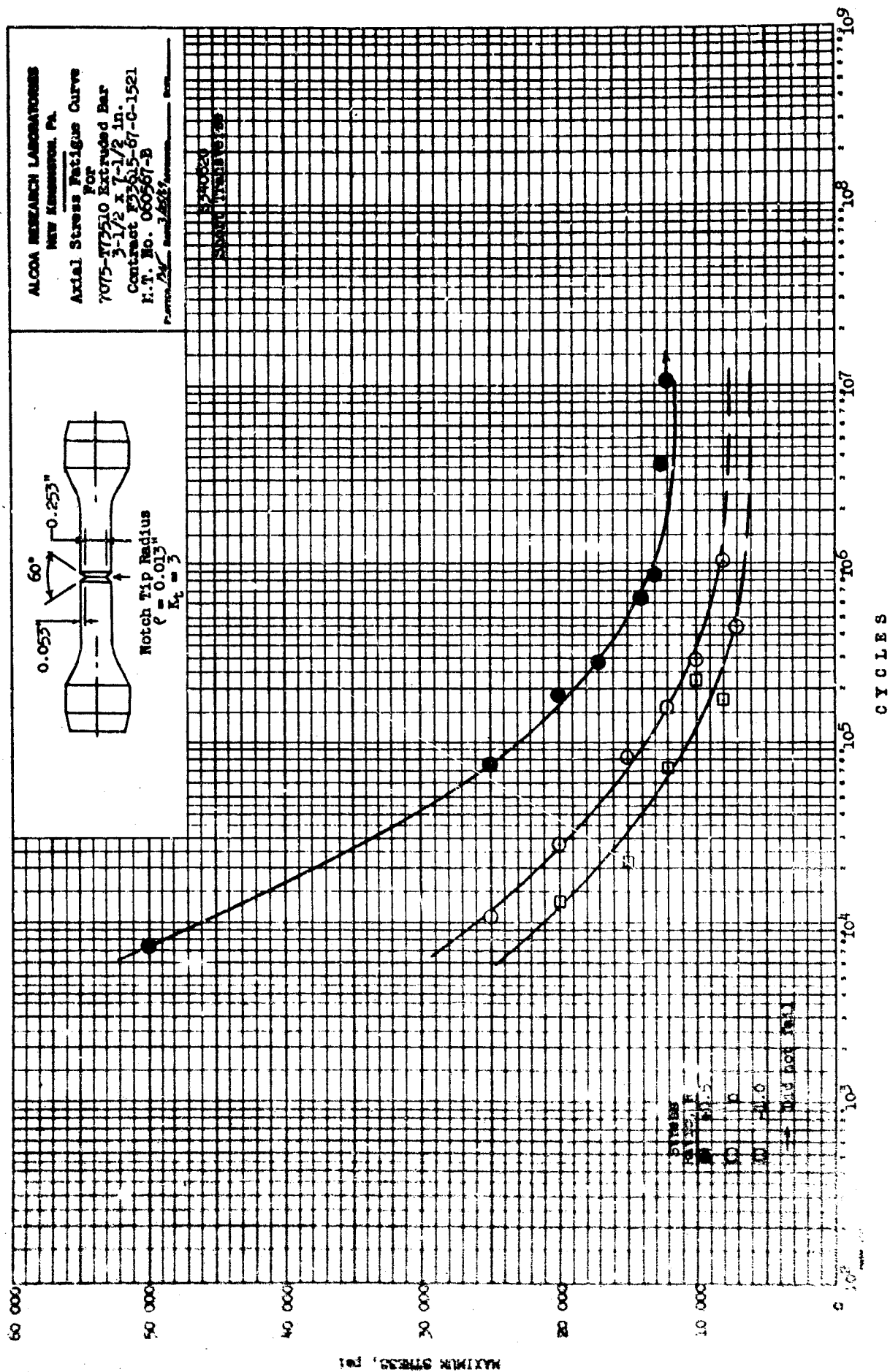


Fig. 11

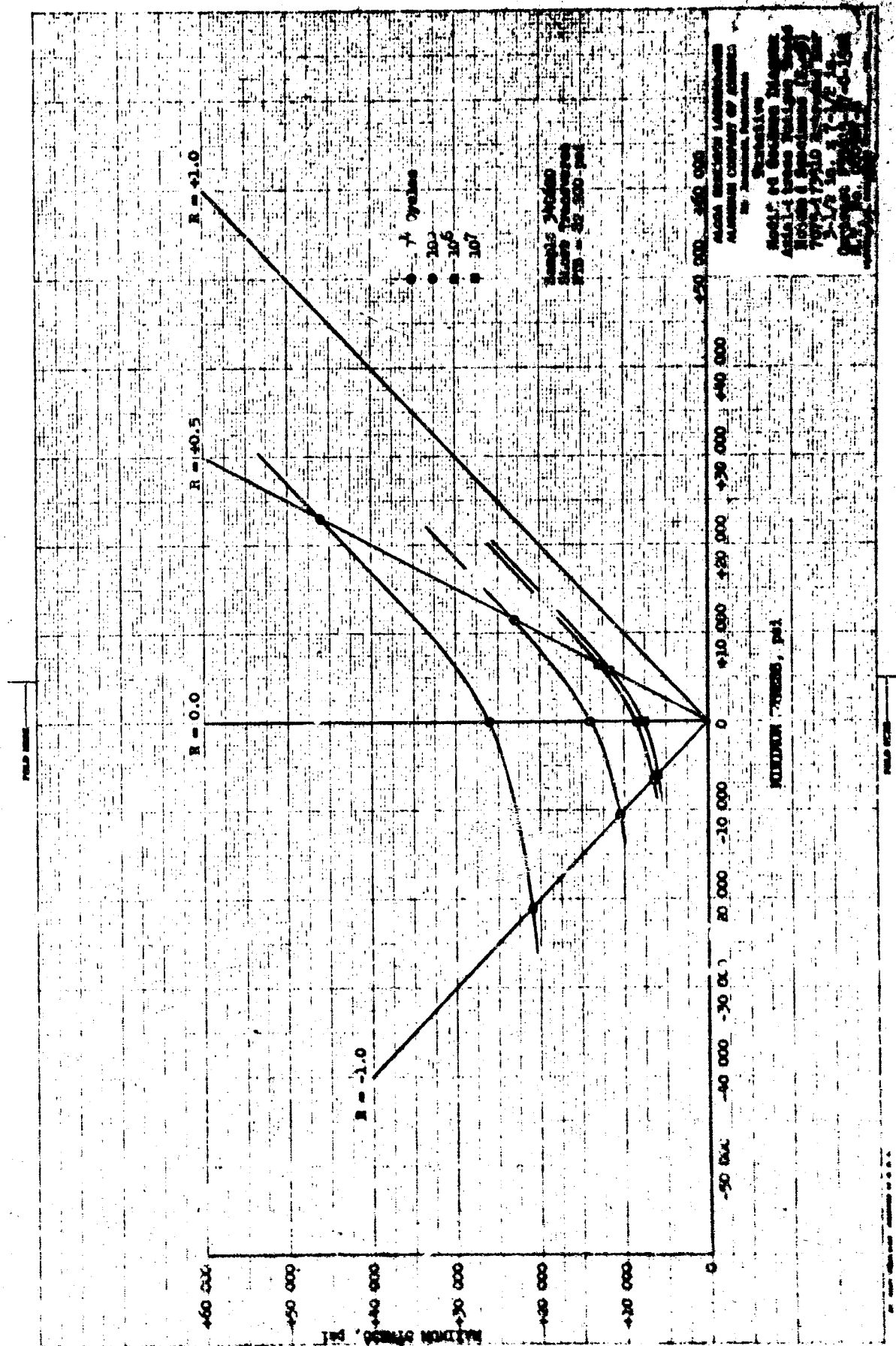


Fig. 12

0.053" 60° 0.053" 0.013" 0.053"

Notch Tip Radius
 $R = 0.013"$
 $K_t = 3$



Fig. 13

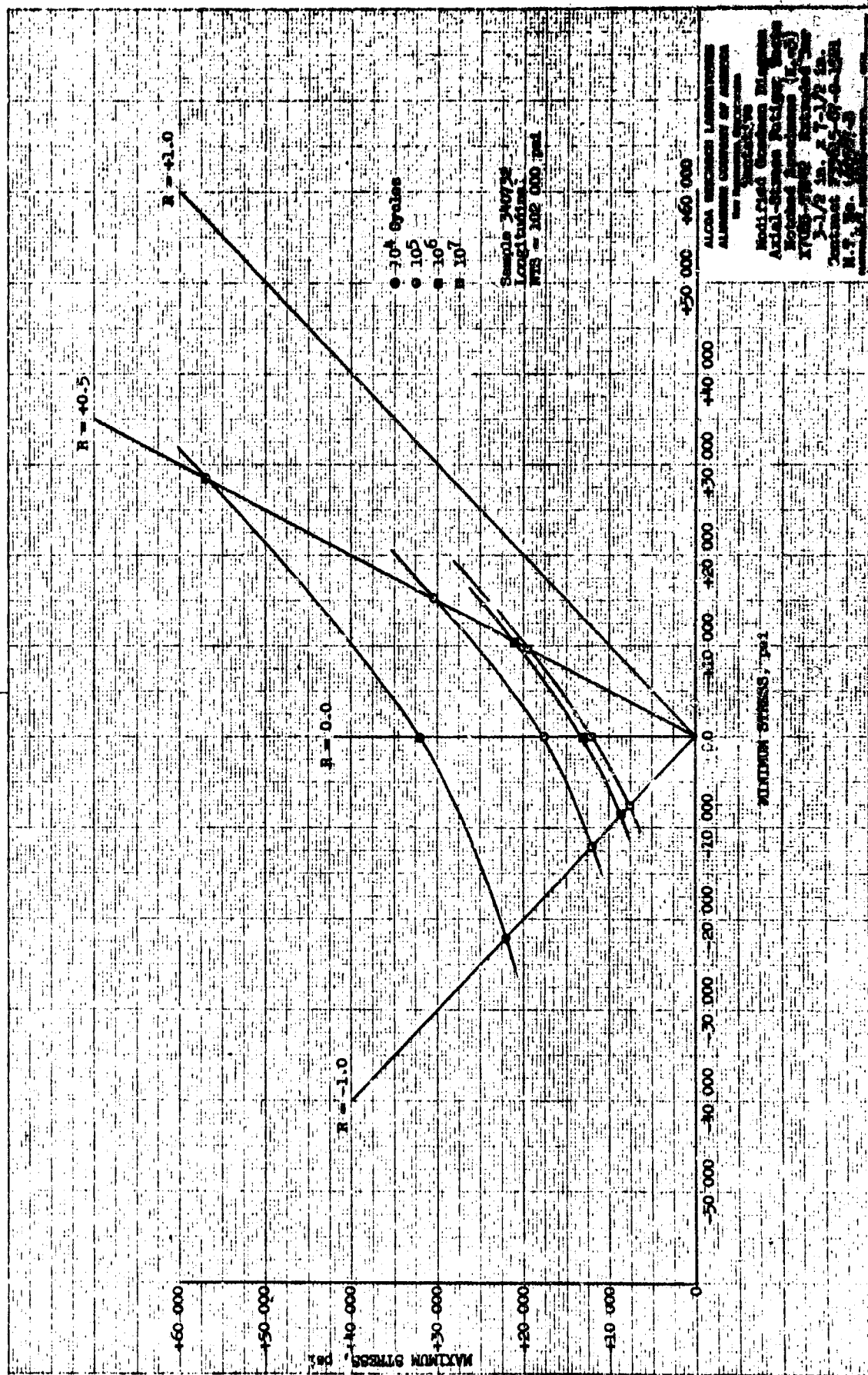


Fig. 14

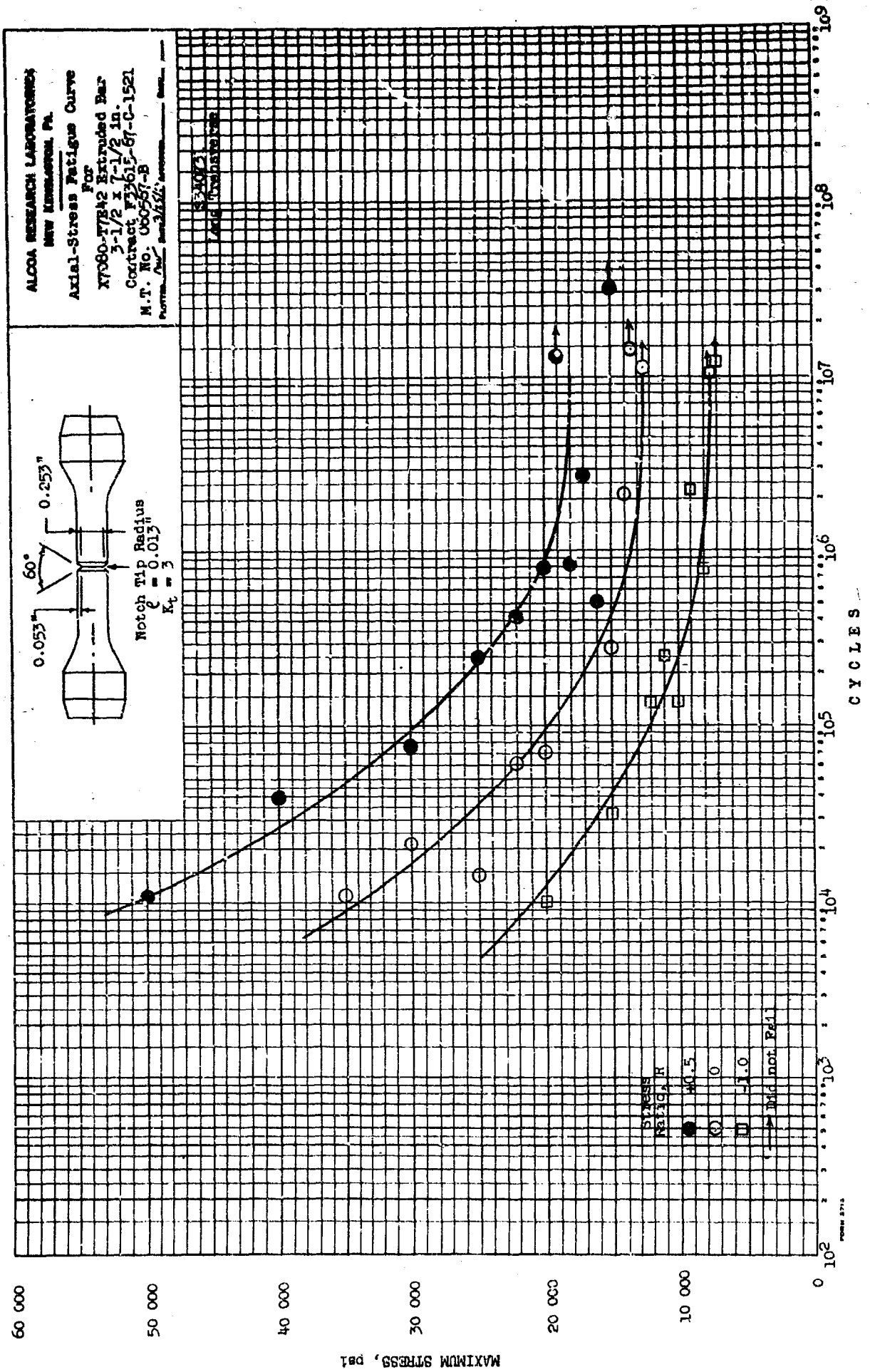


Fig. 15

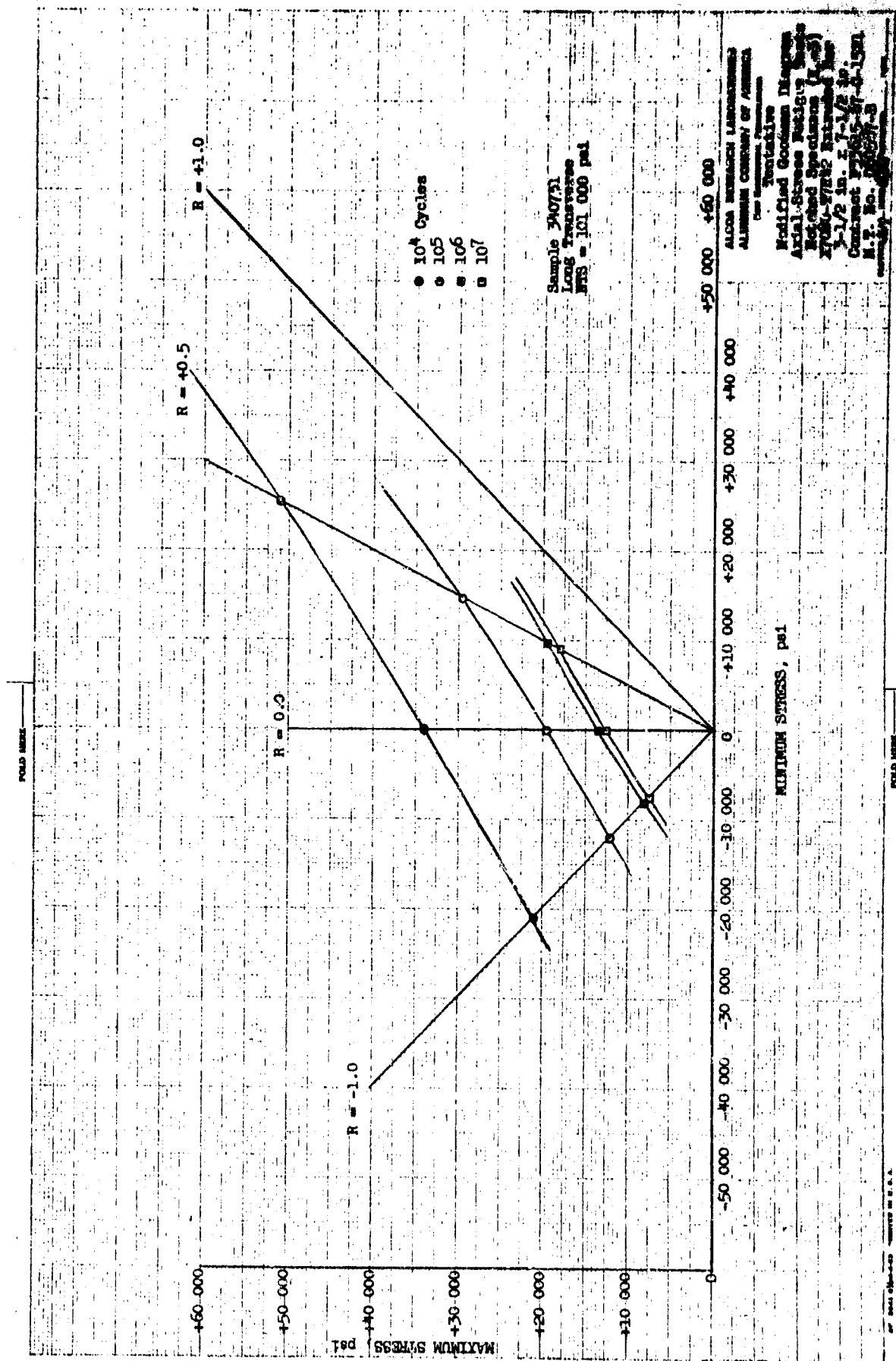


Fig. 16

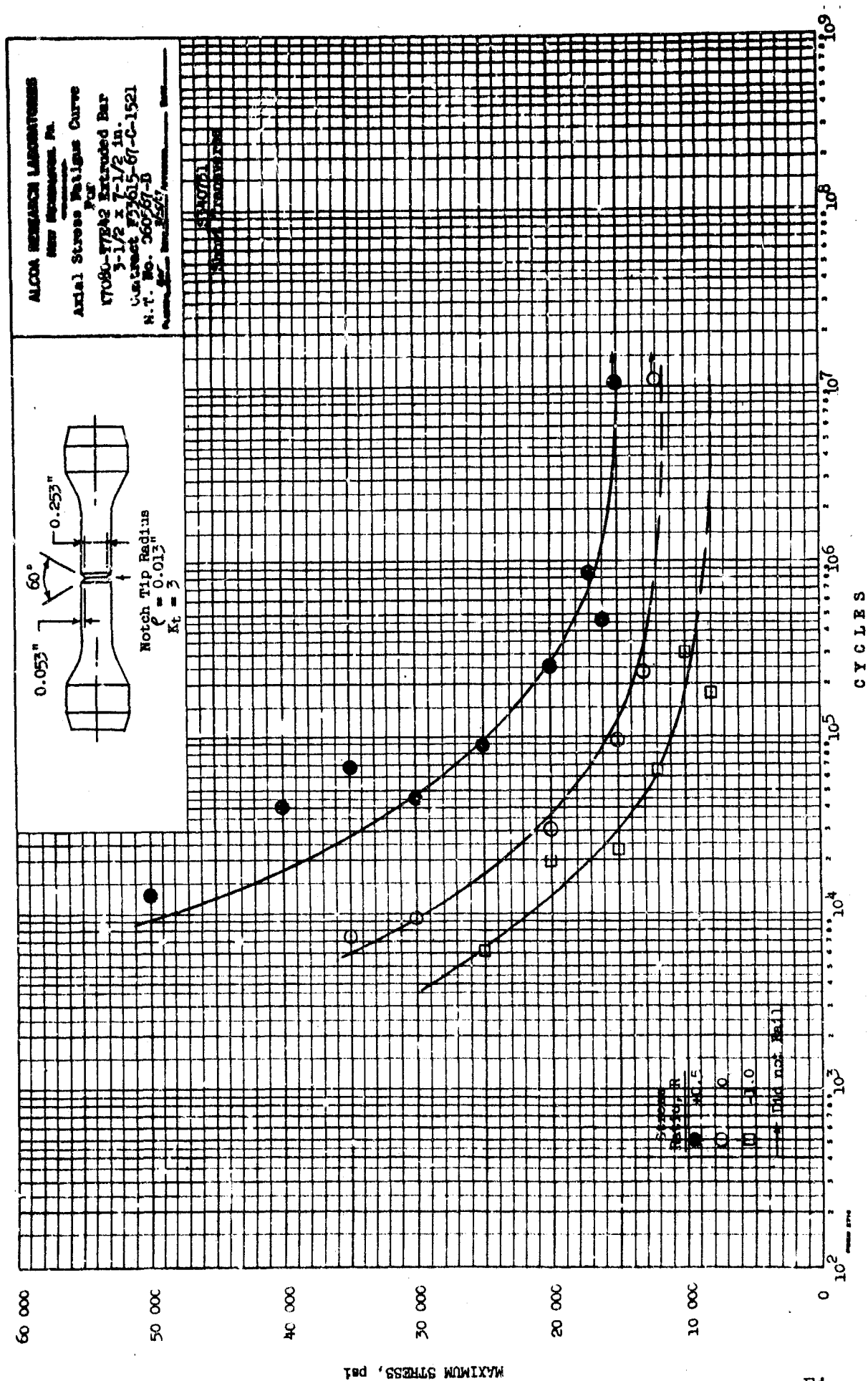


Fig. 17

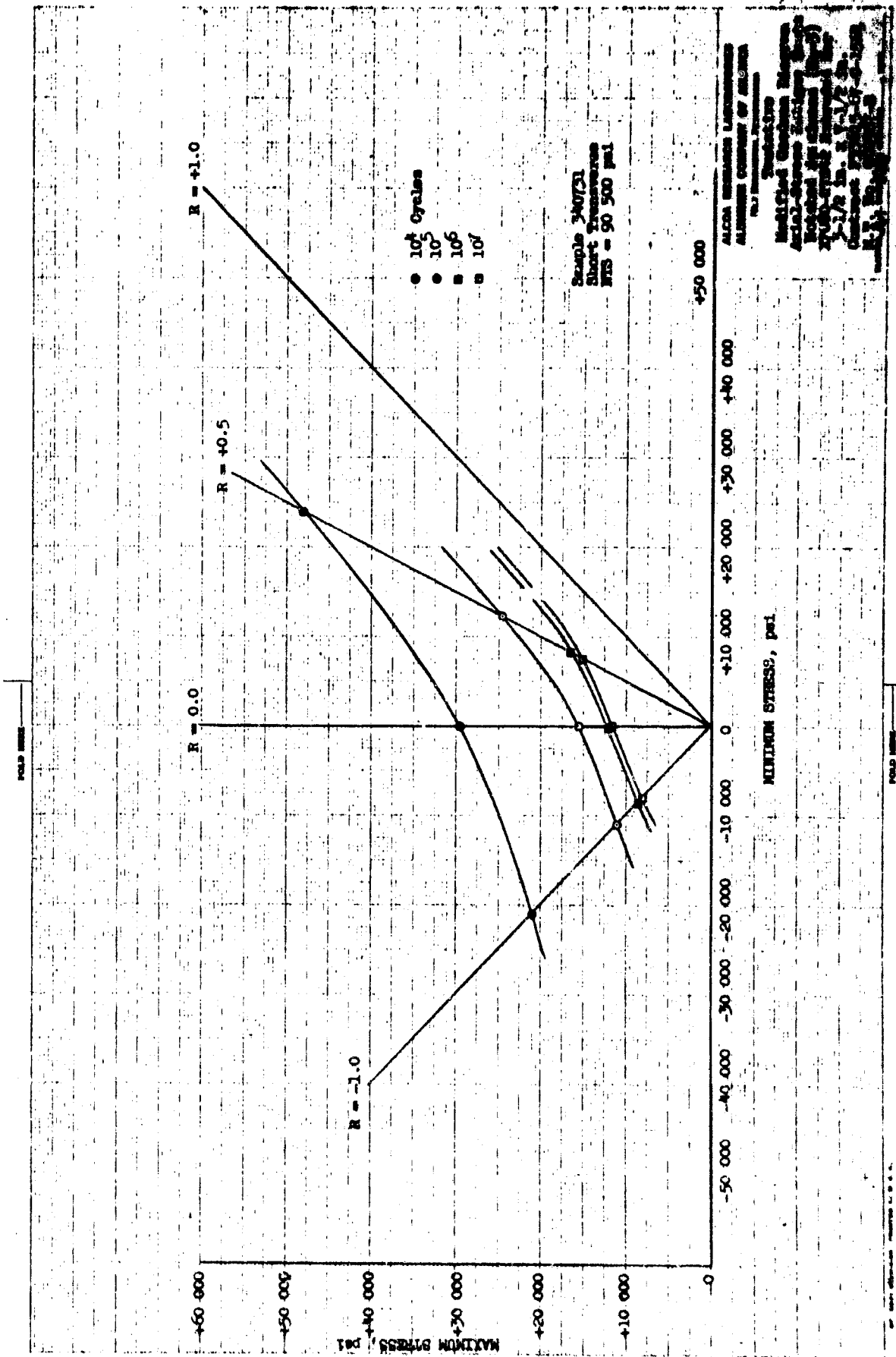


Fig. 18

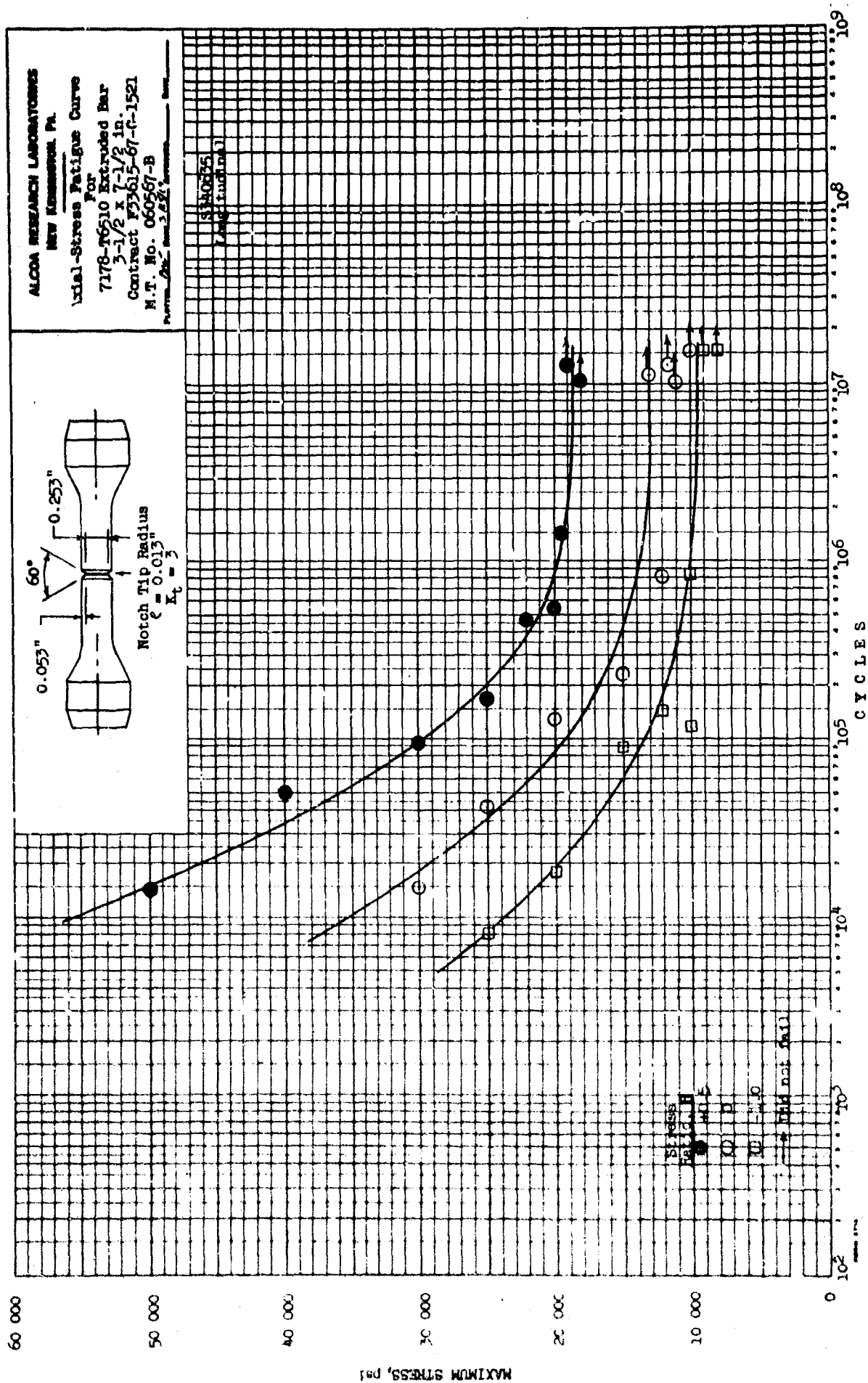


Fig. 19

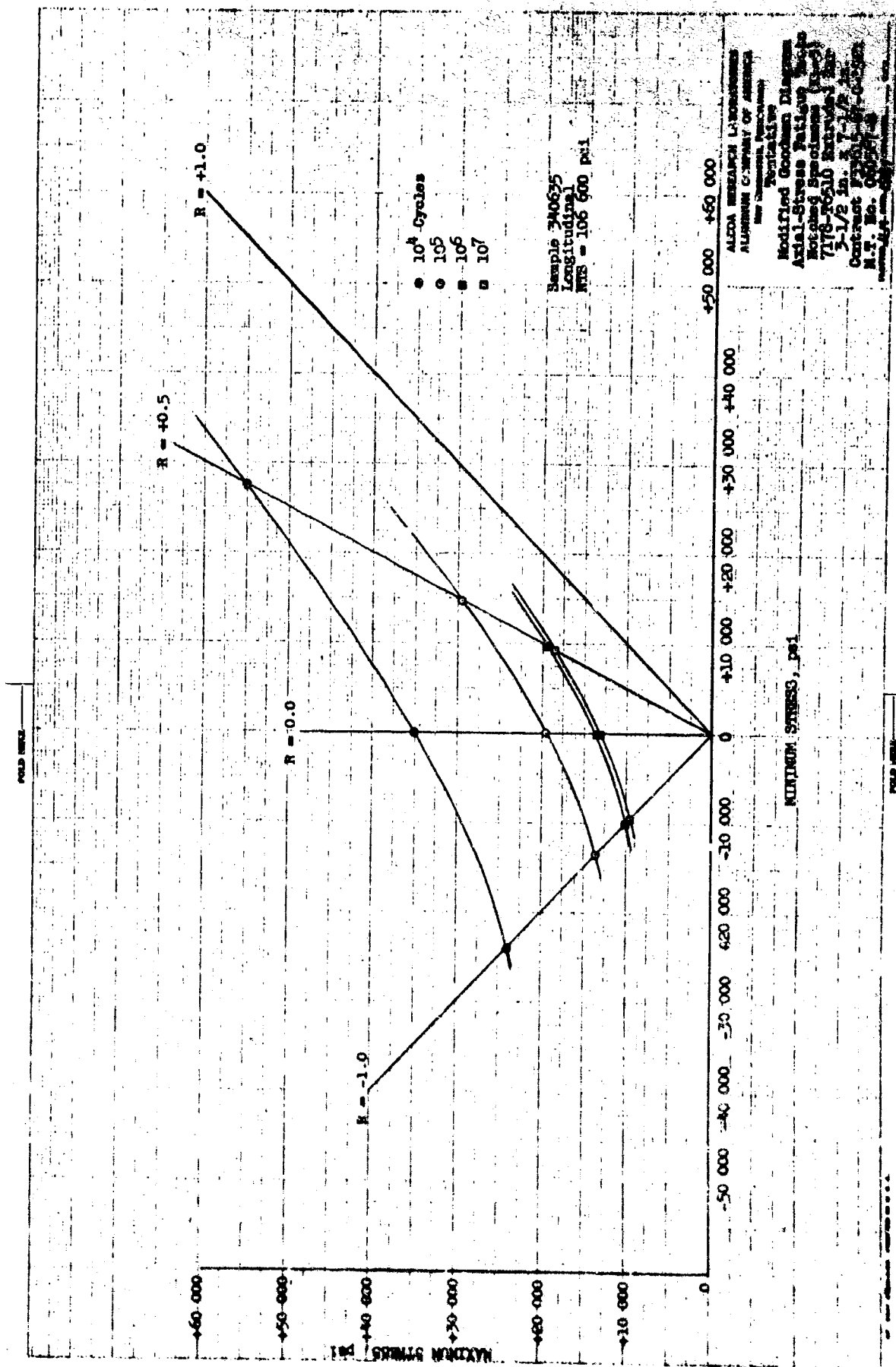


Fig. 20

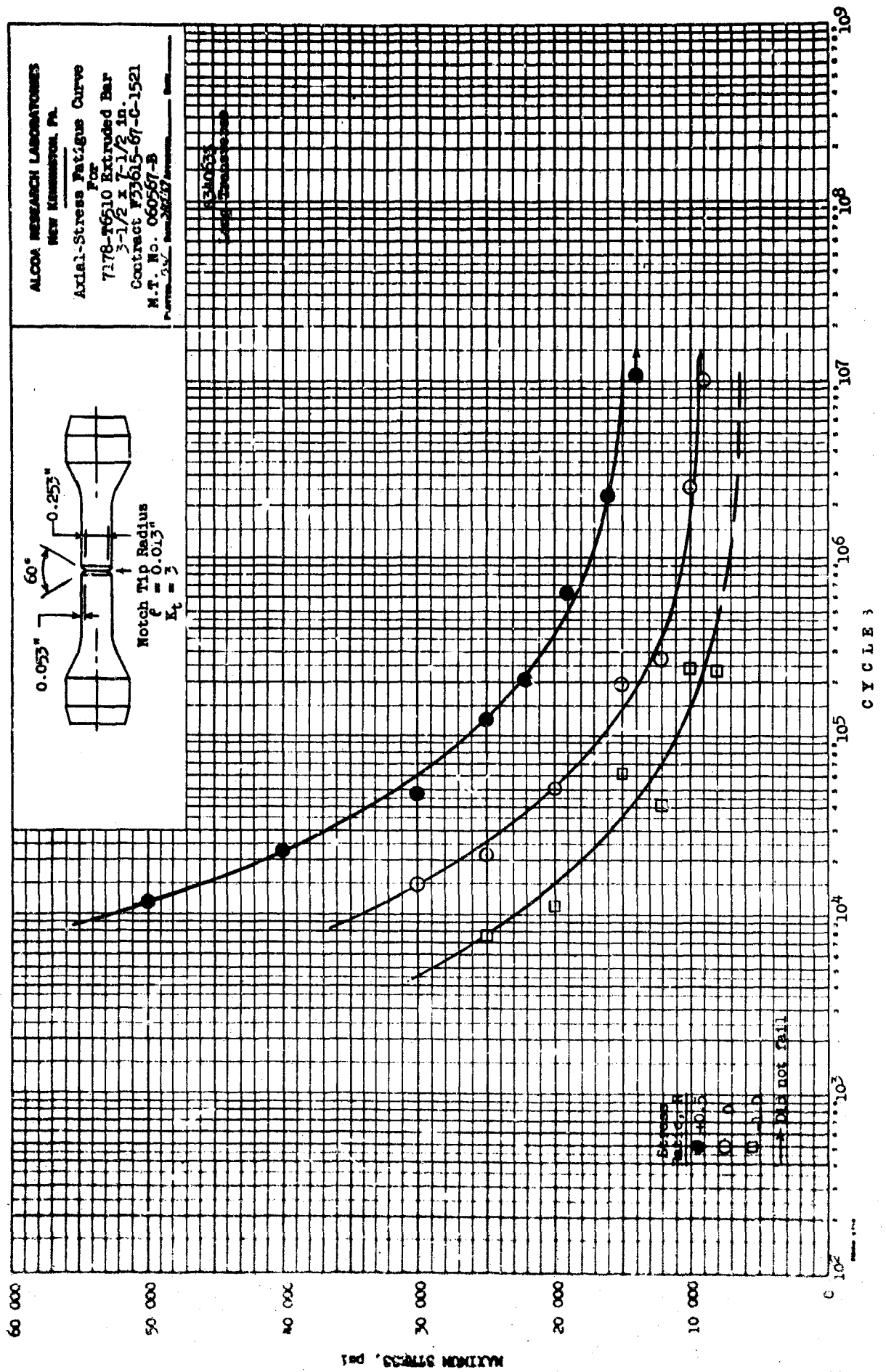


Fig. 21

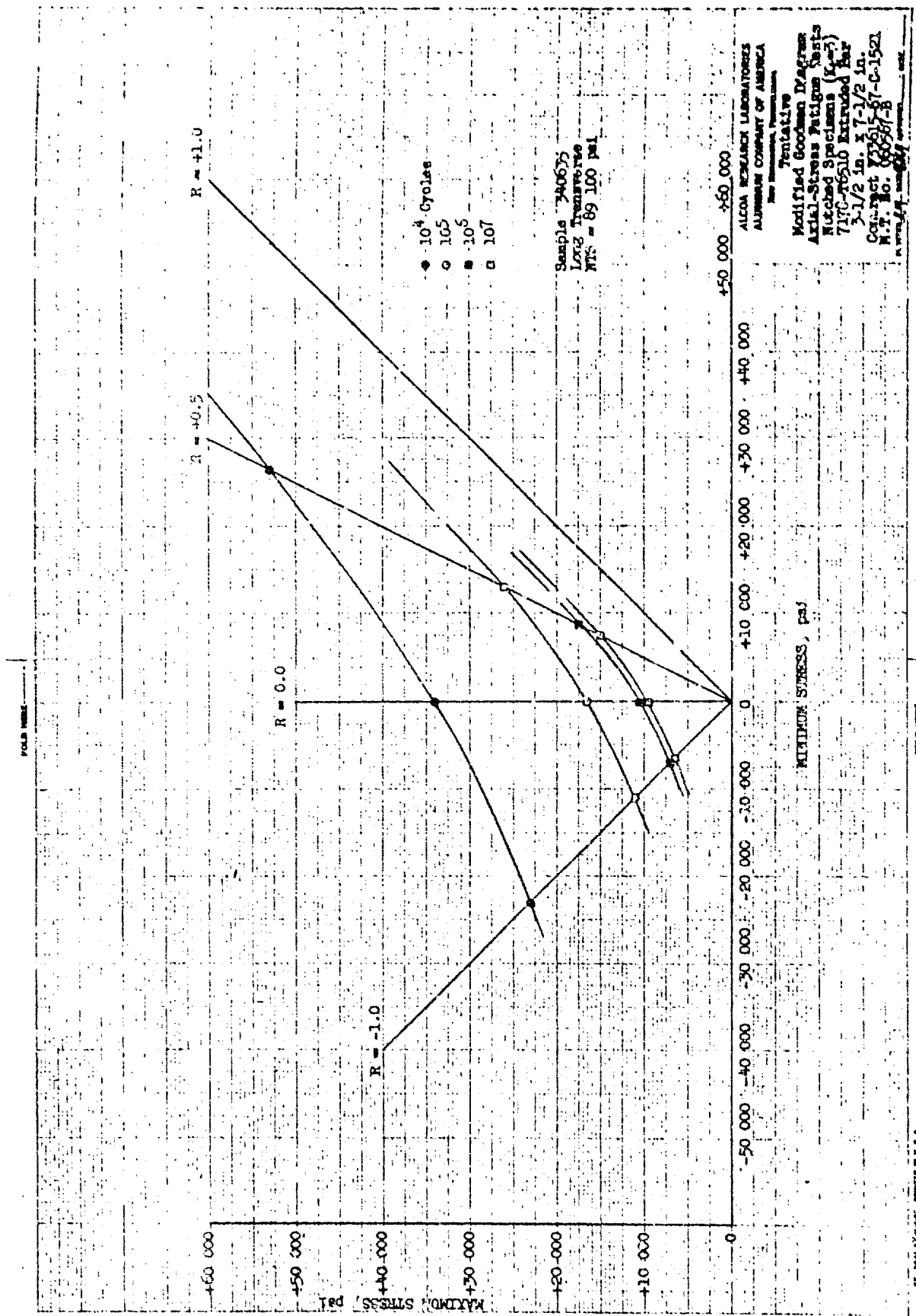
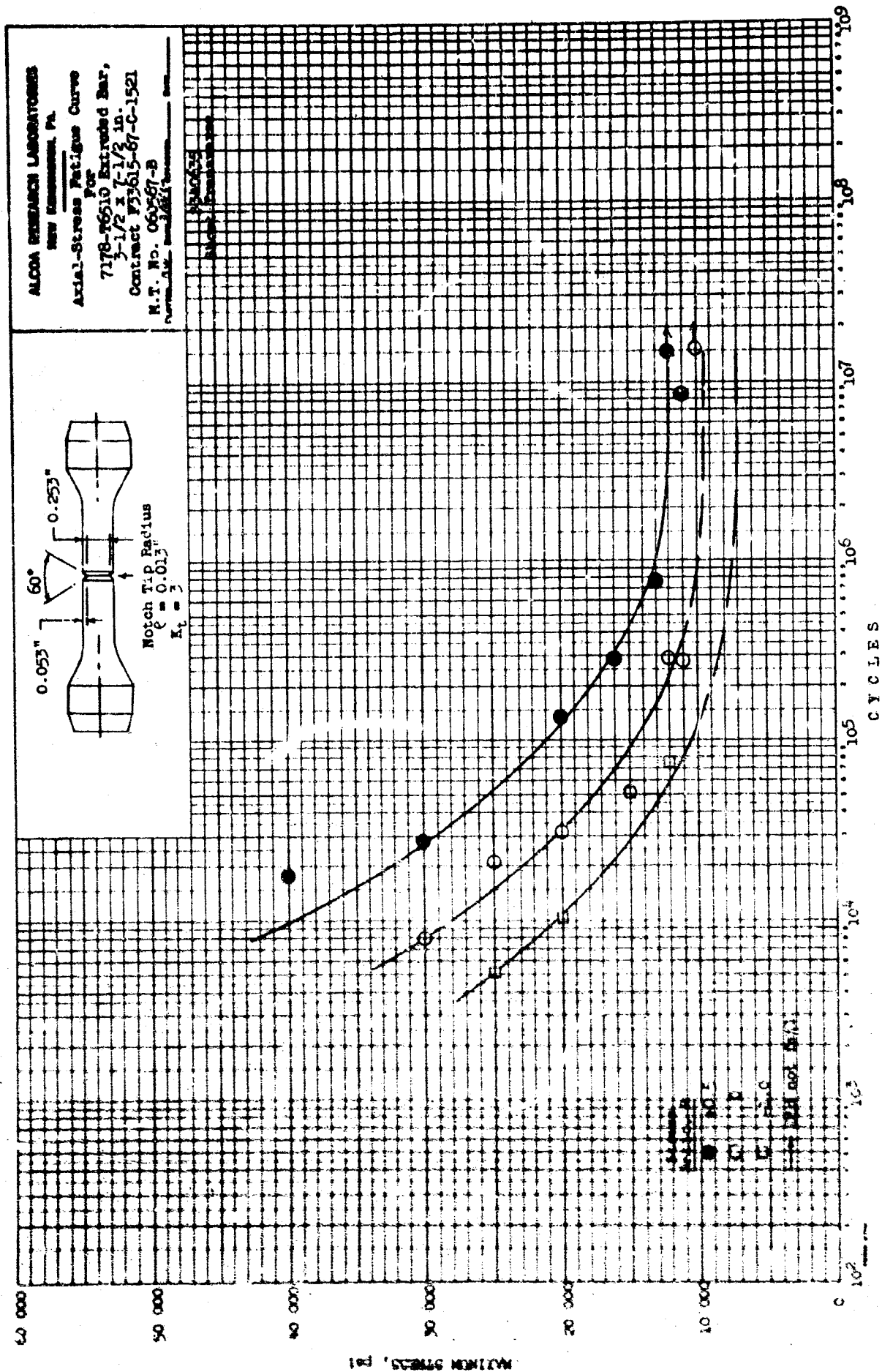


Fig. 22



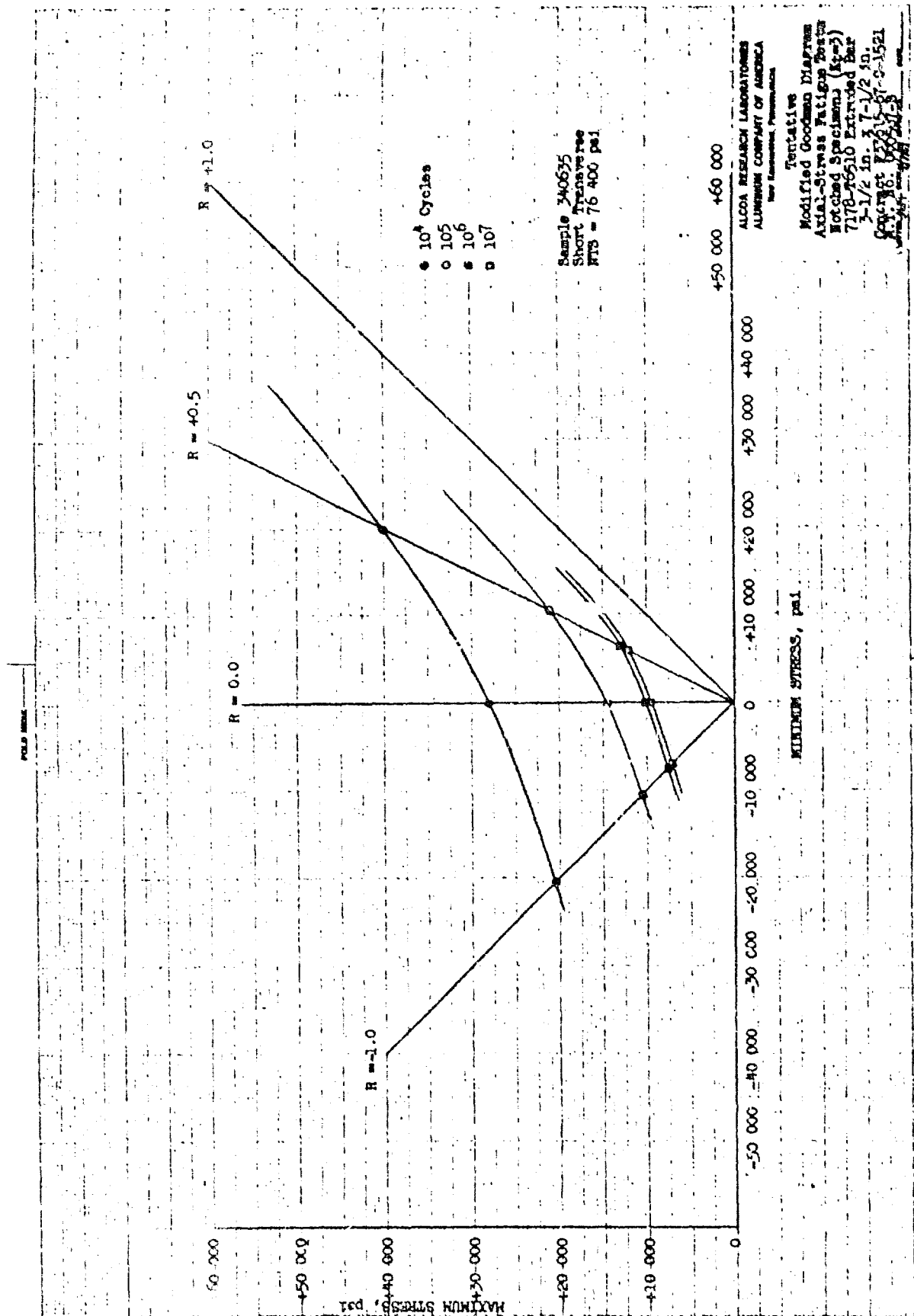


Fig. 24

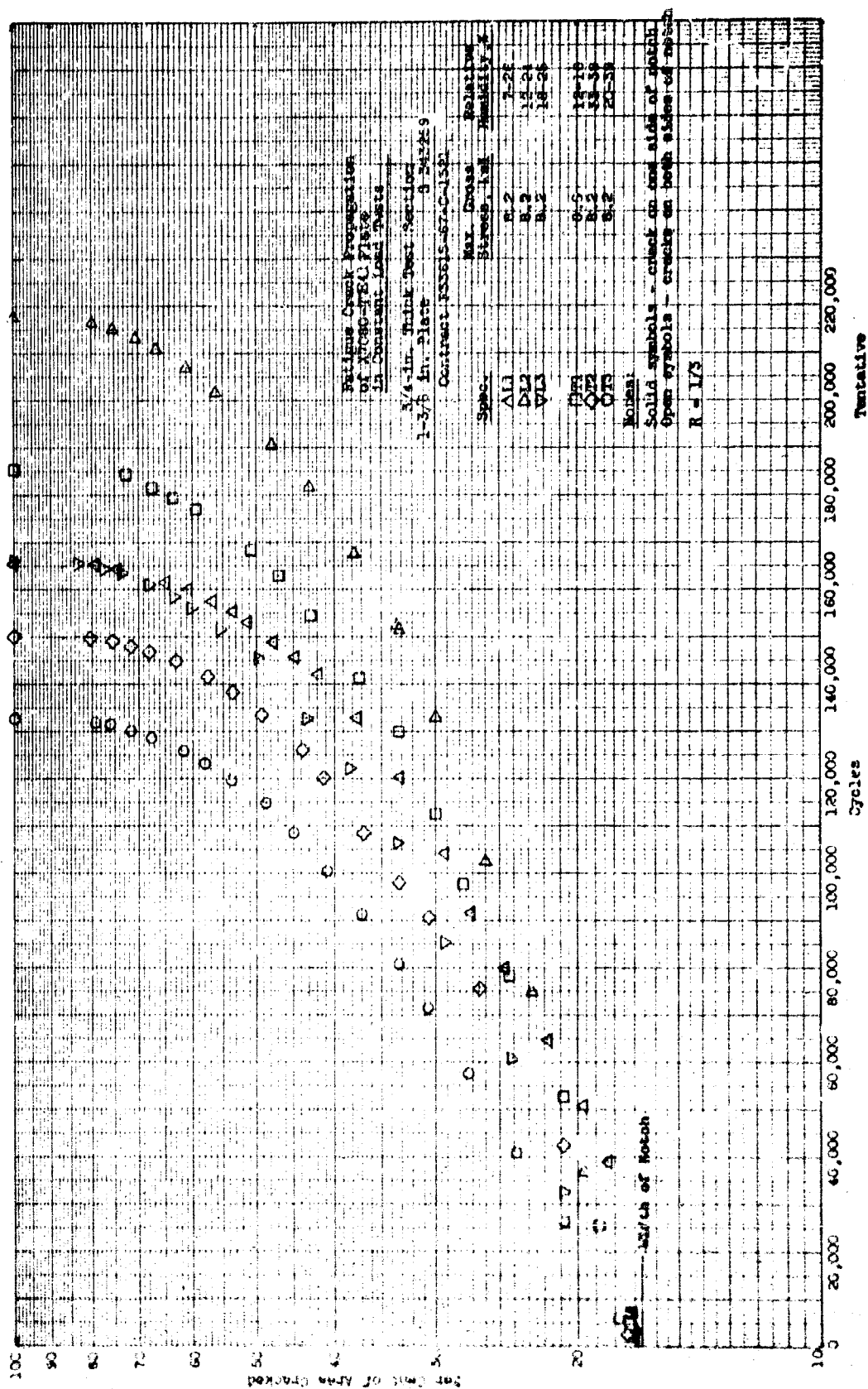


Fig. 26

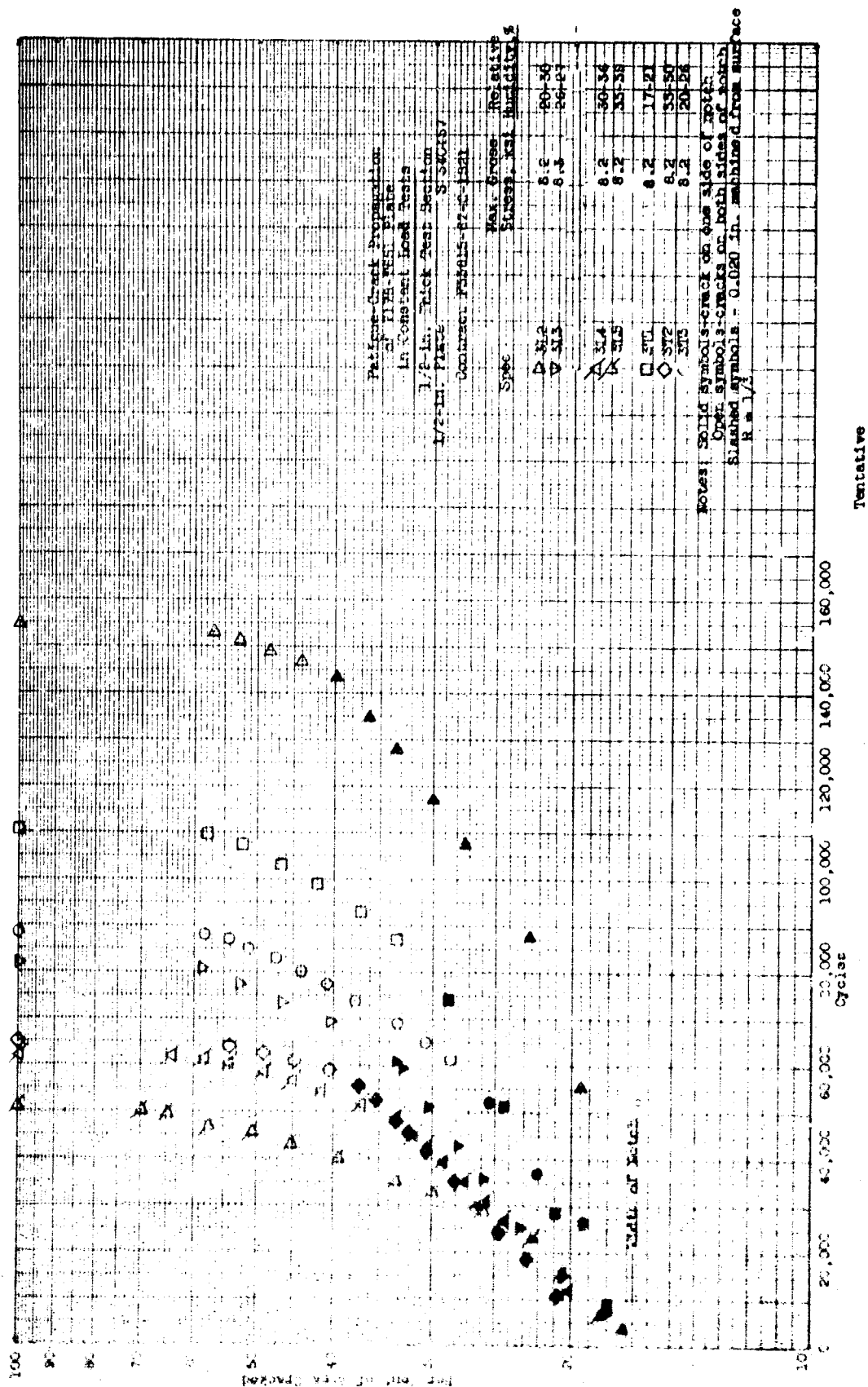


Fig. 27

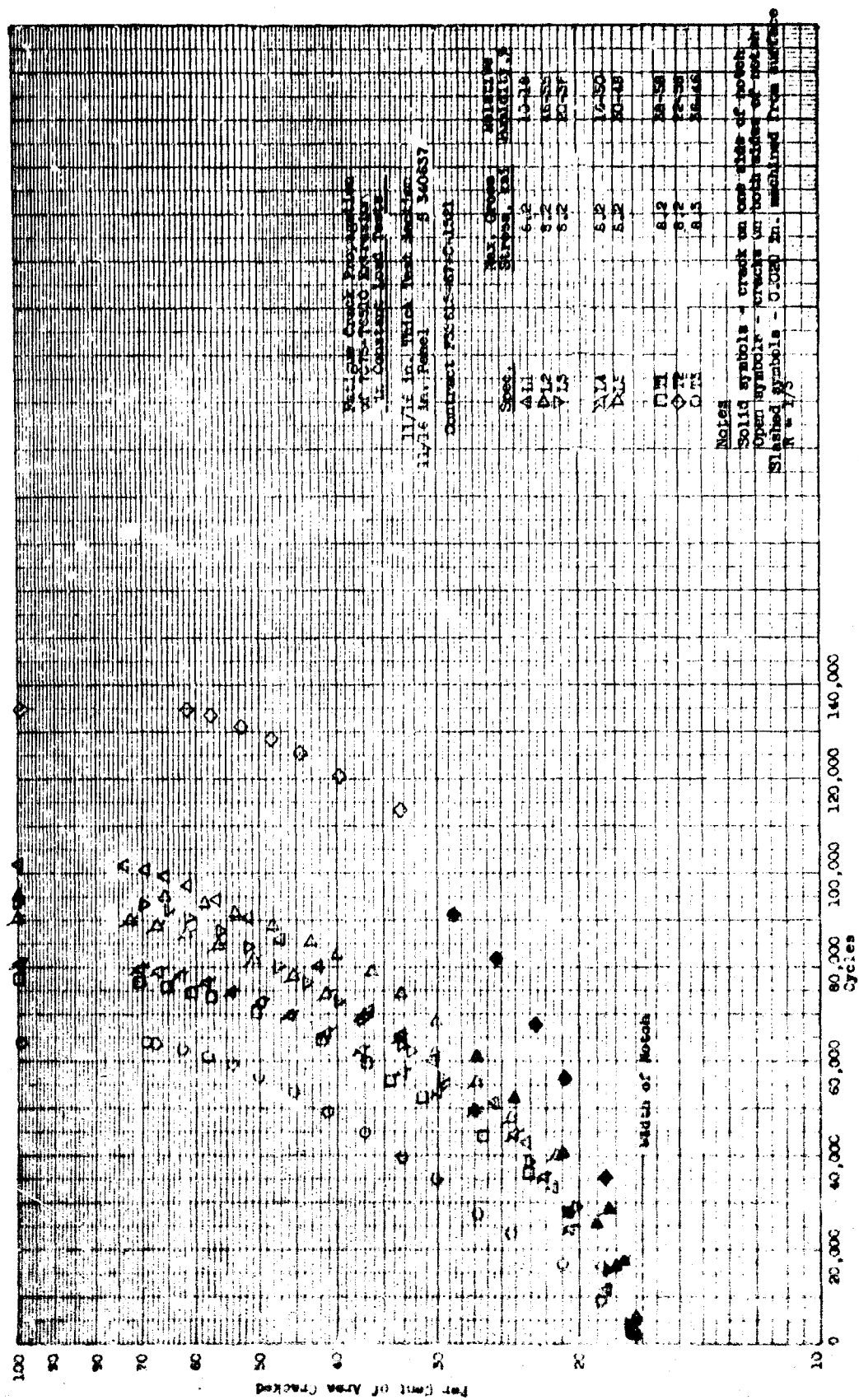
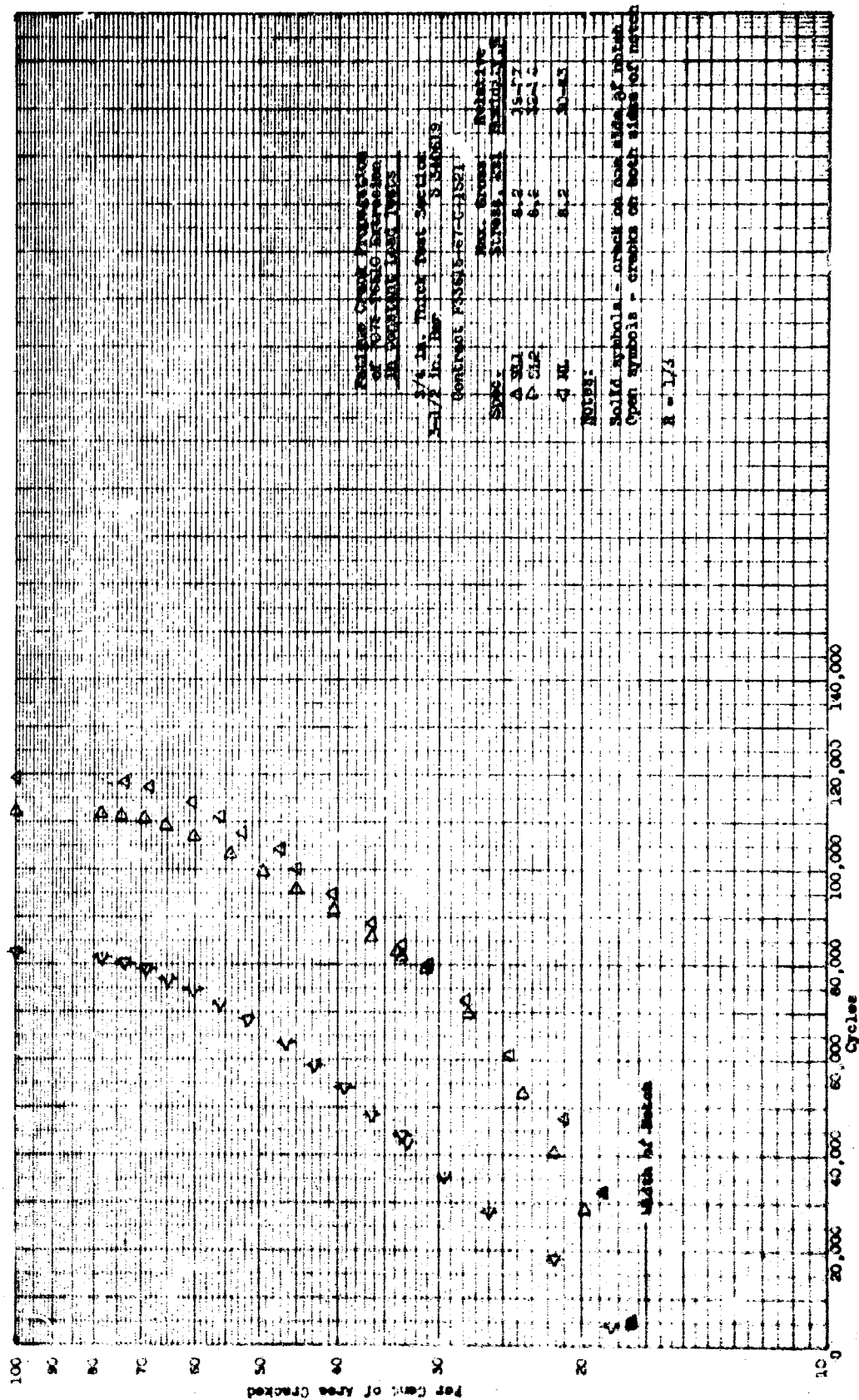
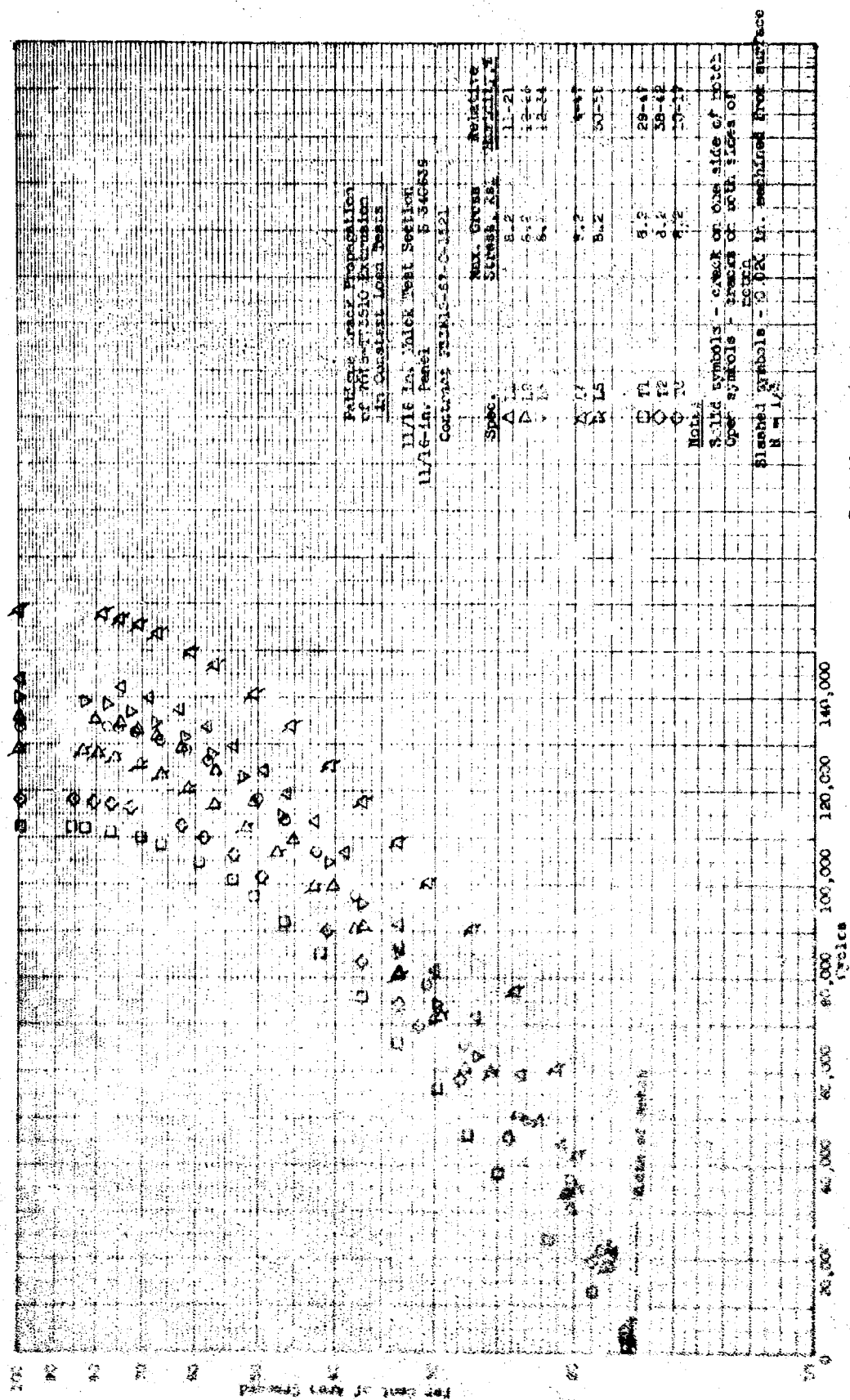


Fig. 29

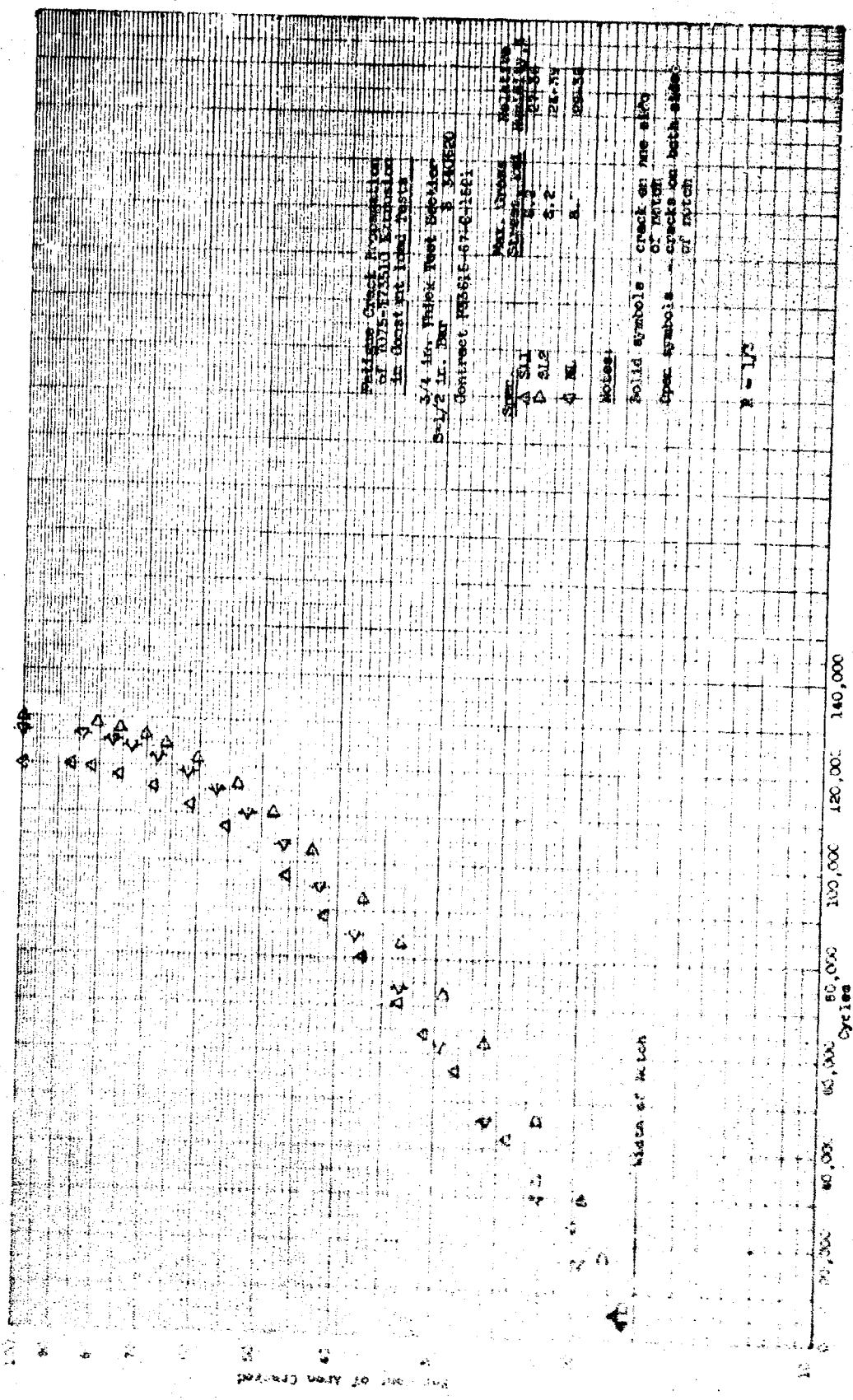


Tentative

Fig. 30



Tentative



Positive Crack Propagation
of 1075-173310 Extrusion
in Constant Load Tests

3/4 in. Index Test Specimen
S-1/2 in. Bar
Contract #38615-0718-1151

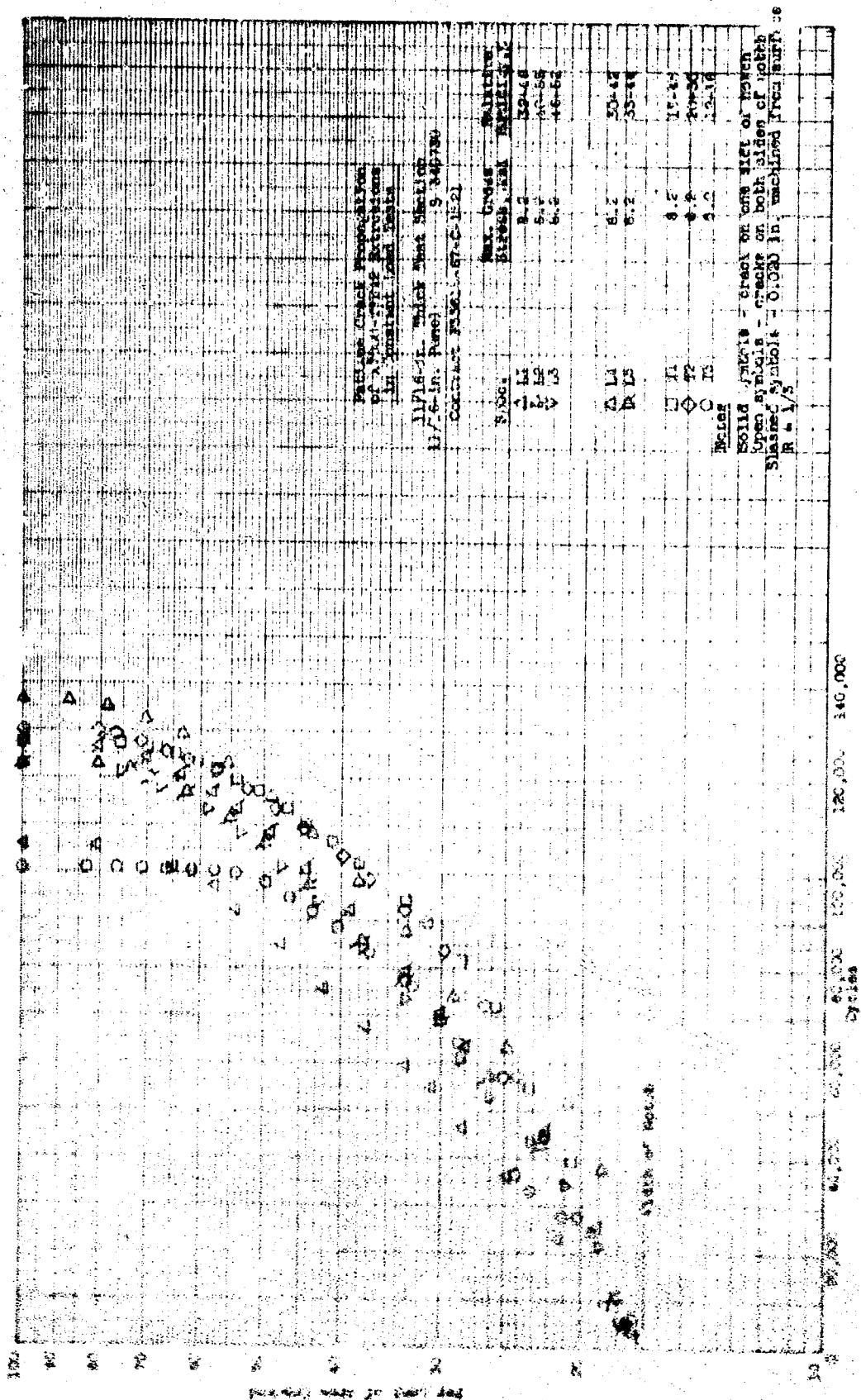
Spec.	Max. Load Stress, ksi	Relative Max. Load Stress, %
Δ S11	8.3	24.34
Δ S12	8.2	24.19
Δ S13	8.1	24.04

Notes:

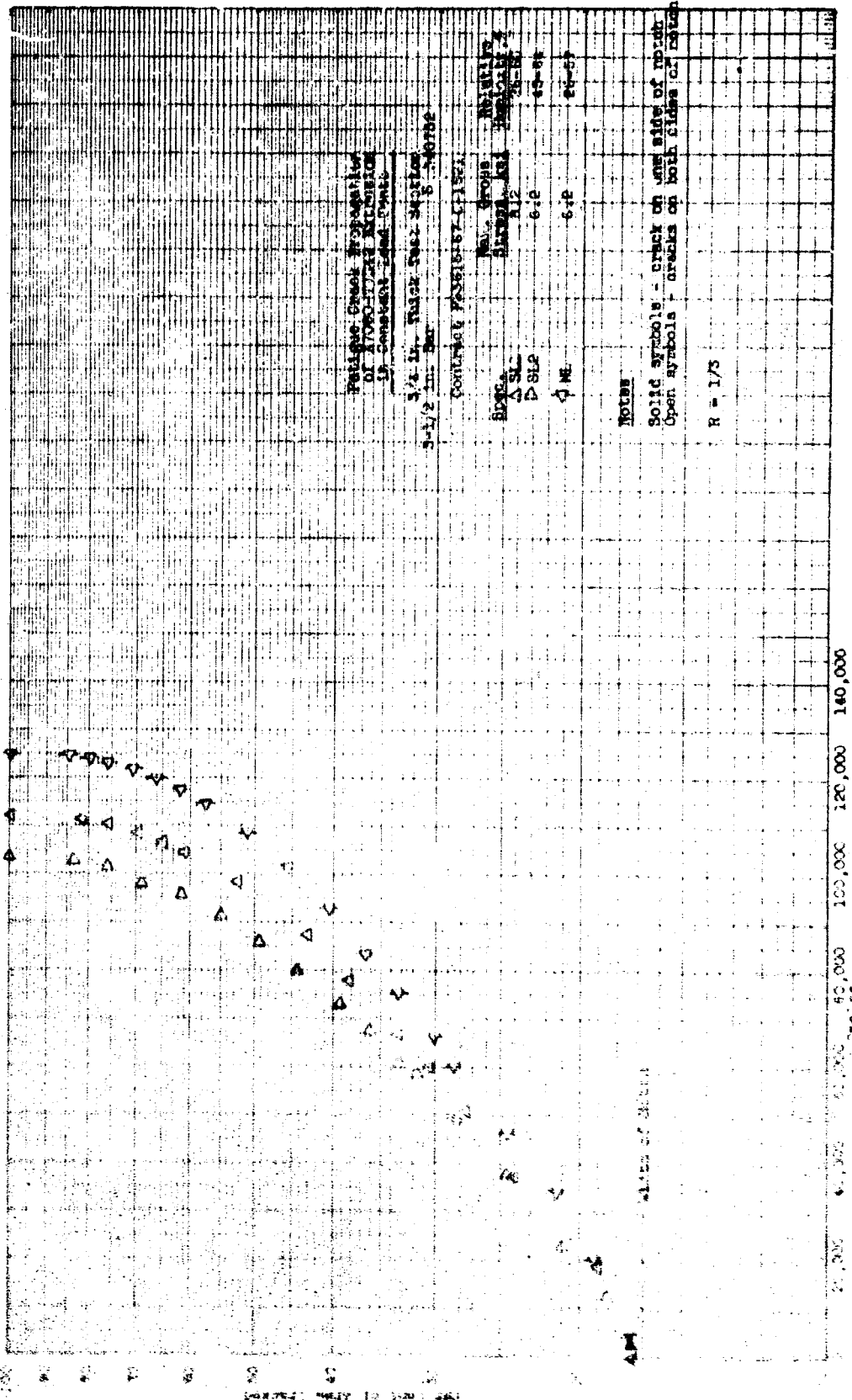
Solid symbols - crack on one side
of patch
Open symbols - cracks on both sides
of patch

P-173

Tentative



Tentative



Fatigue Crack Propagation
of 1700-1723 Series
in Constant Load Tests

3/4 in. Toler Test Section
3-1/2 in. Bar

Control Register-11521

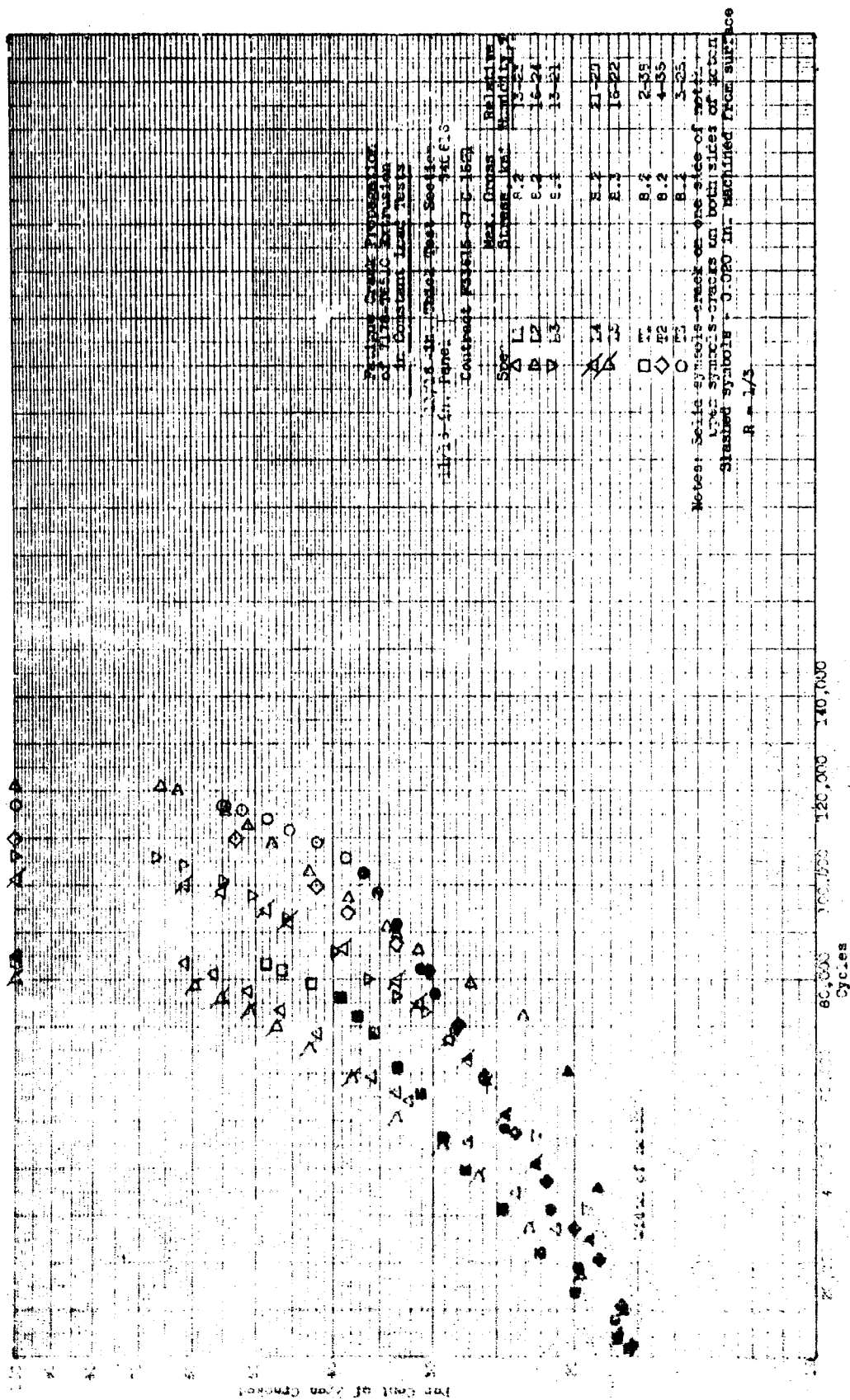
Spec.	Max. Gross Stress, ksi	Relative Humidity, %
Δ 51	6.2	65-85
Δ 52	6.2	65-85
Δ 53	6.2	65-85

Notes

Solid symbols - crack on one side of notch
Open symbols - cracks on both sides of notch

R = 1/3

Tentative



Tentative

Fig. 35

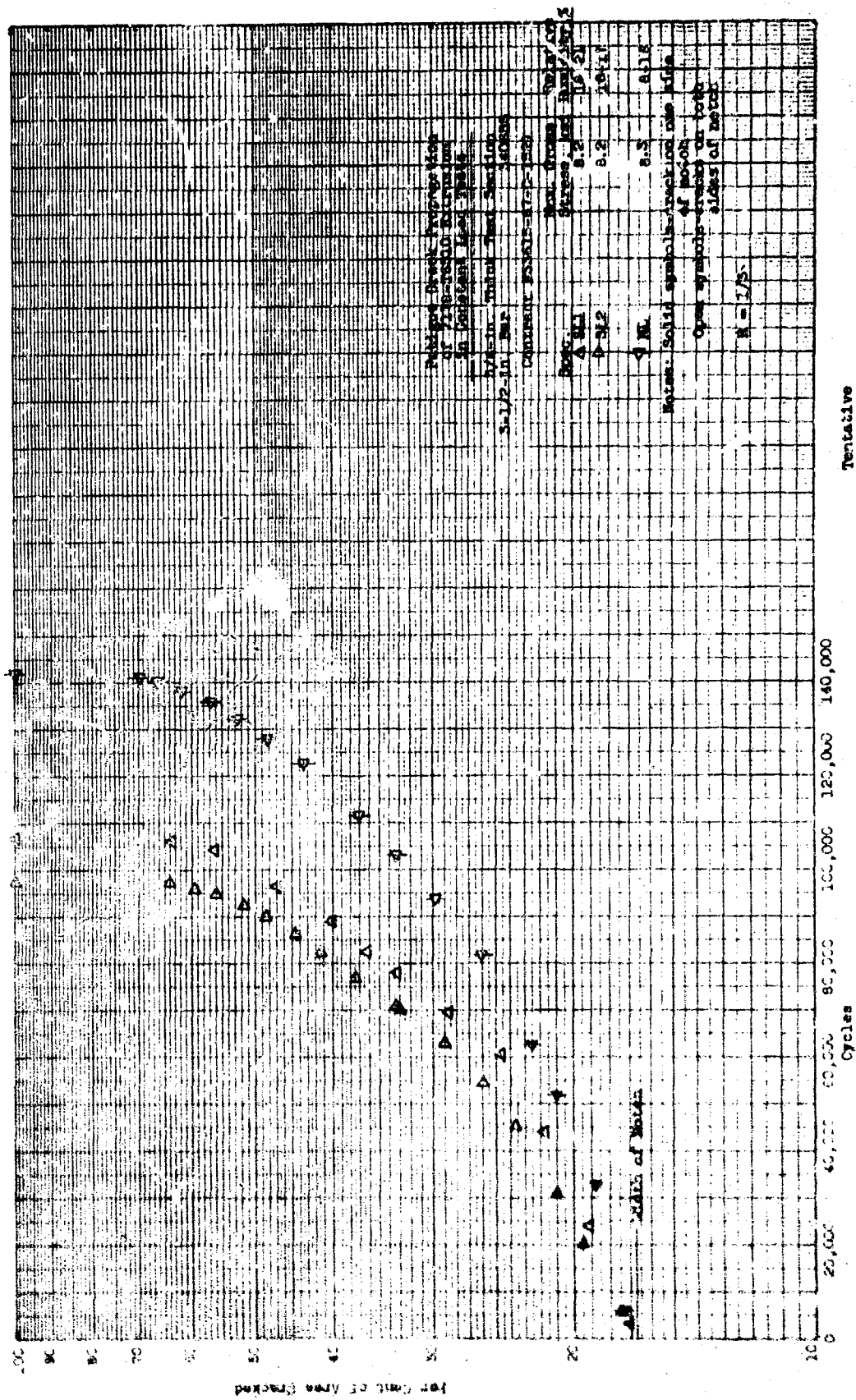


Fig. 36

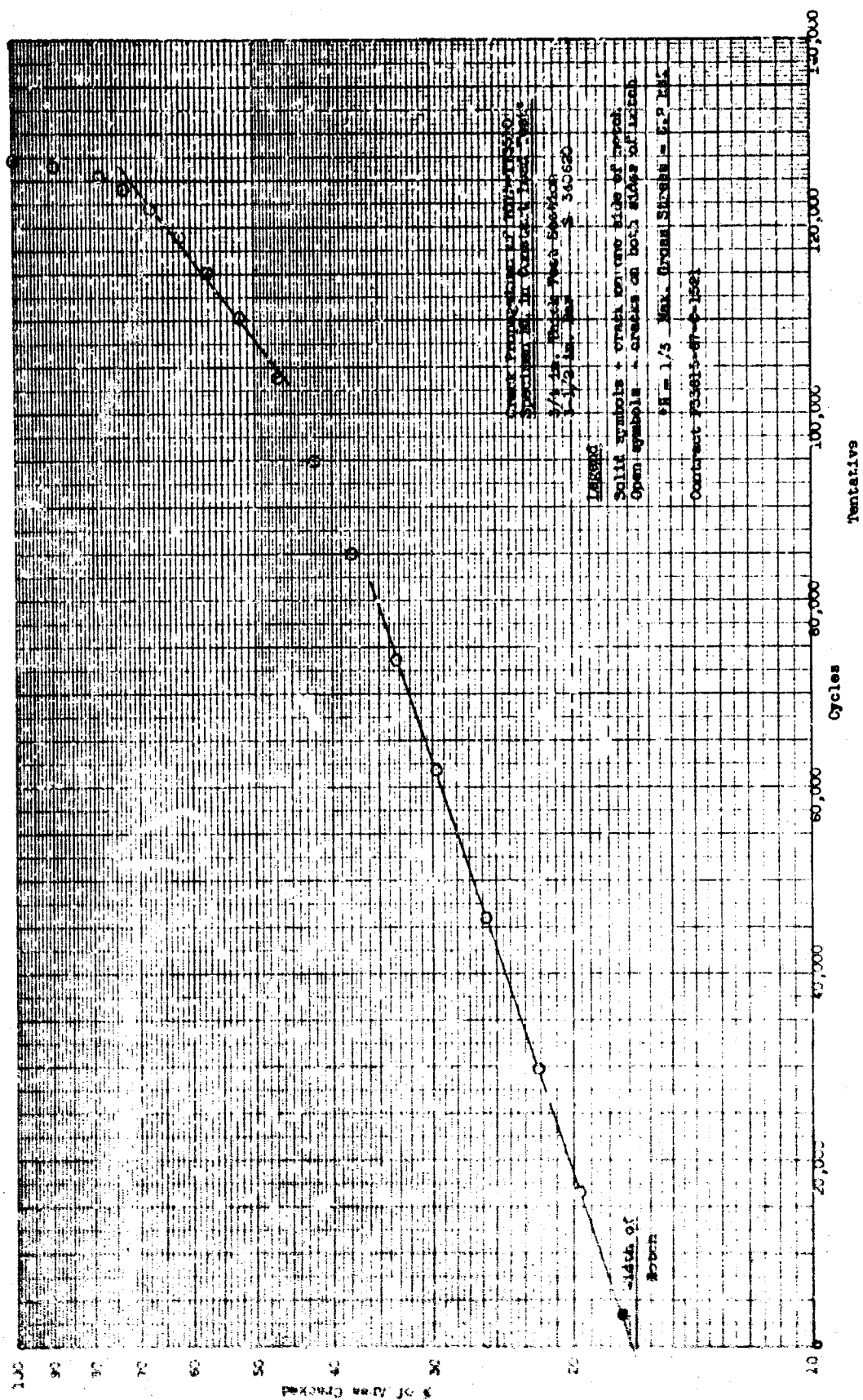


Fig. 37

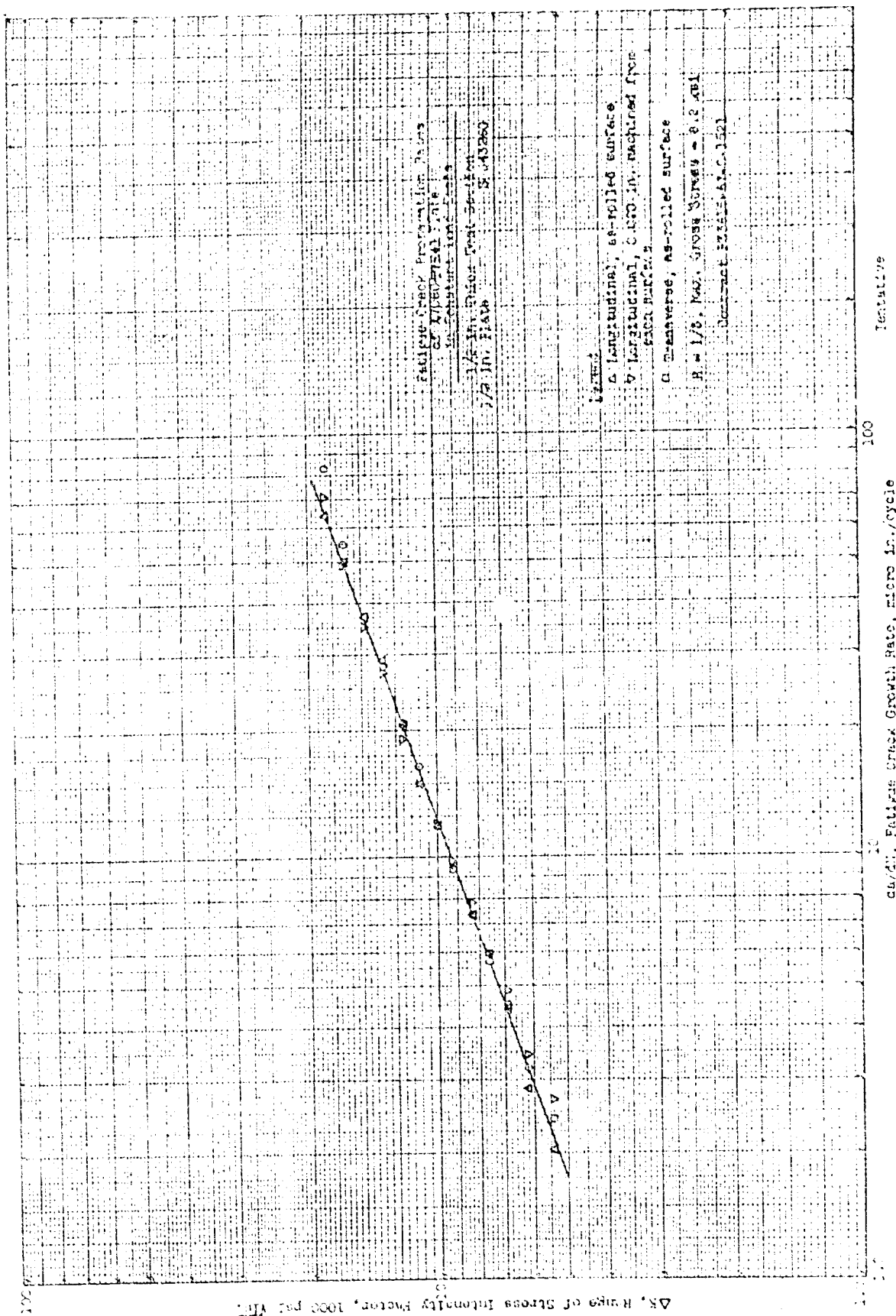


Fig. 38

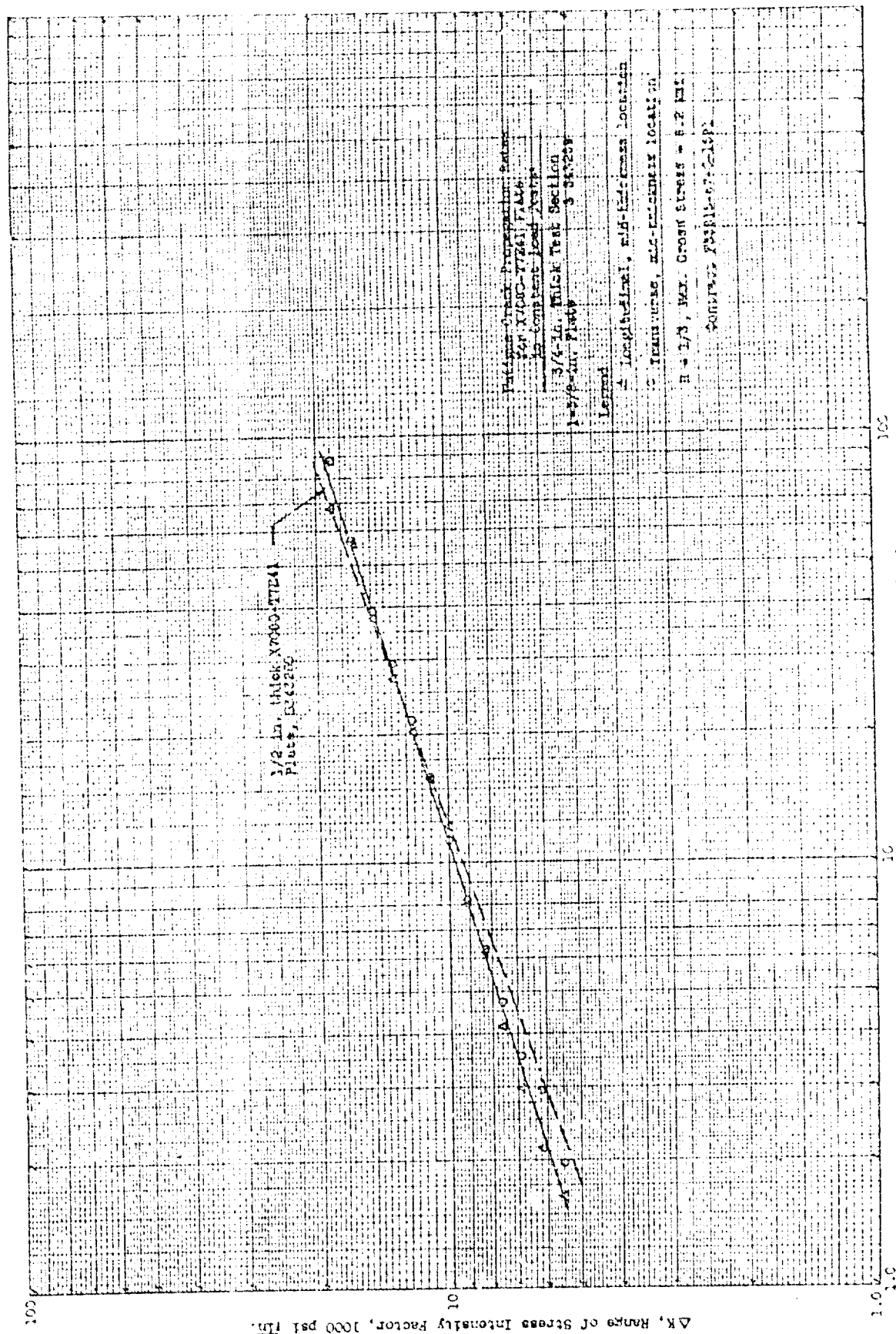


Fig. 39

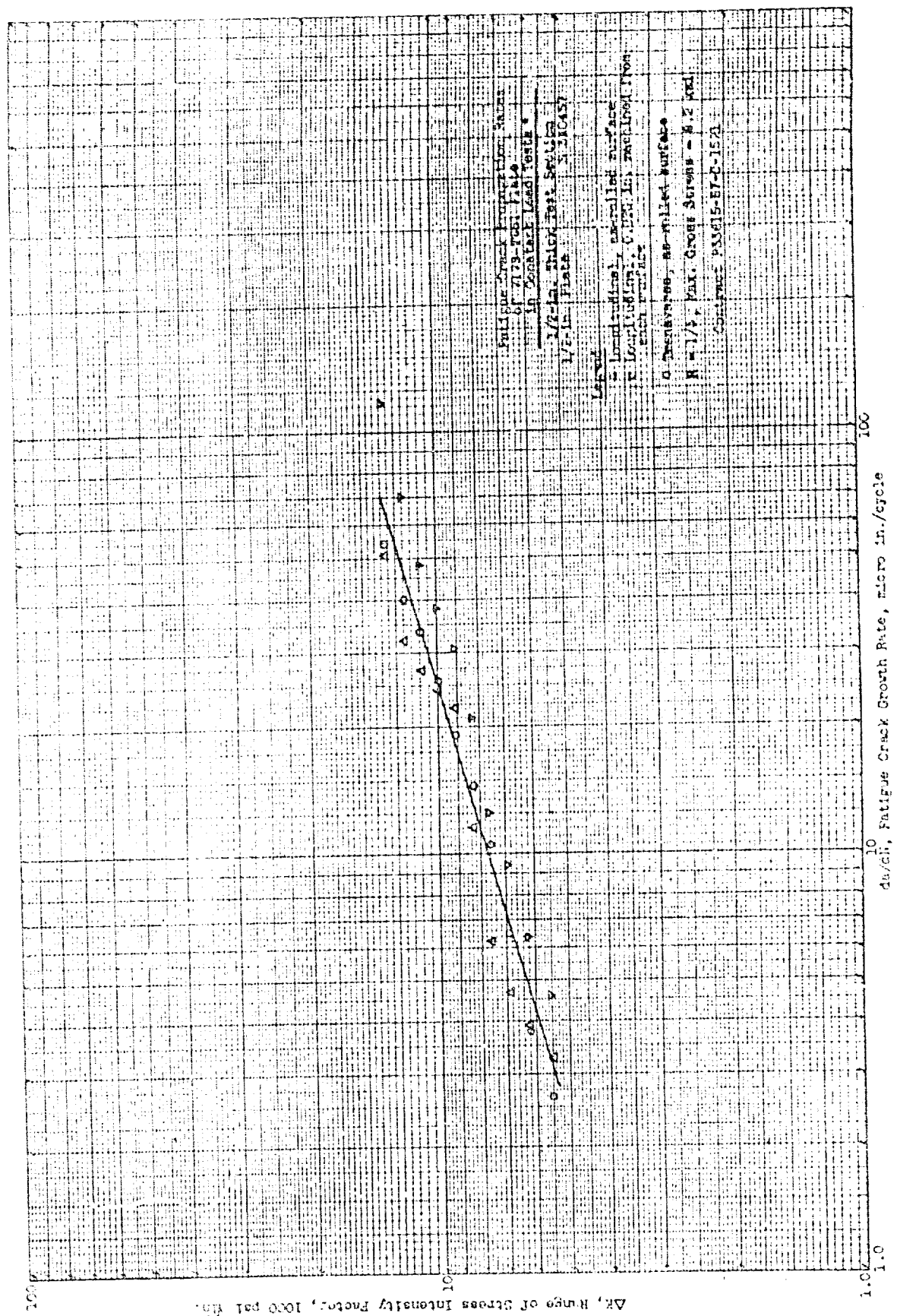
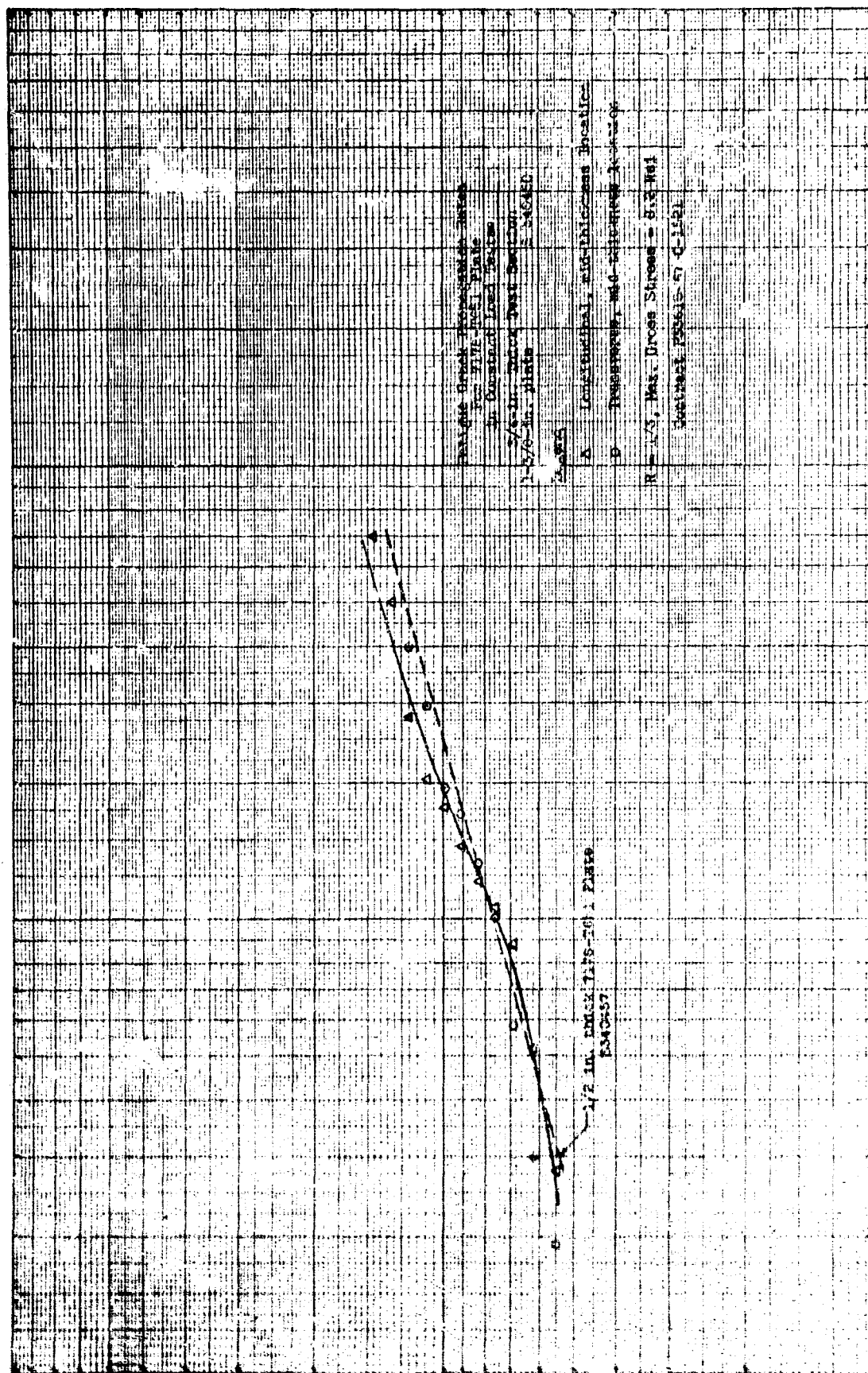


Fig. 40



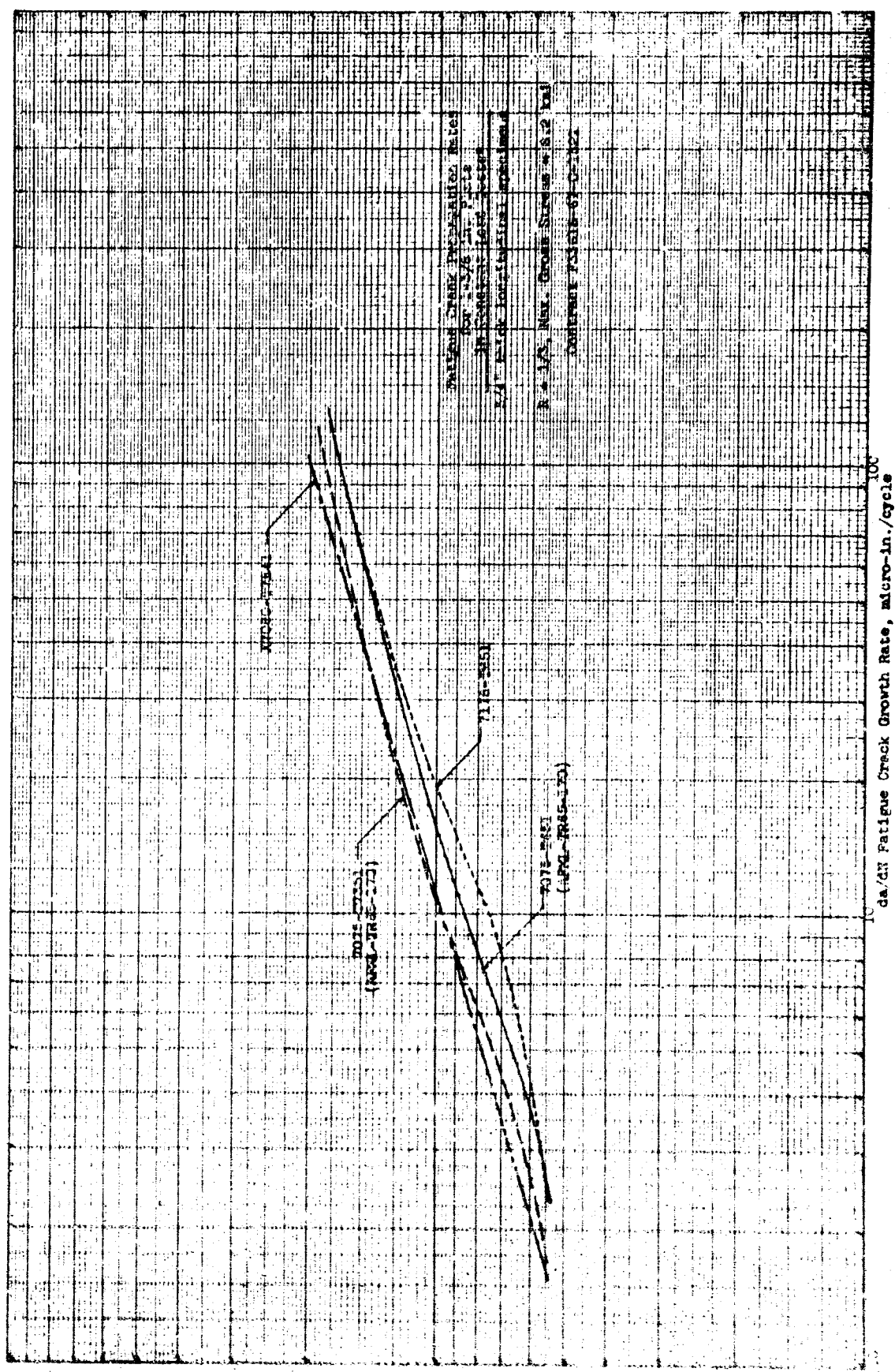
242 IN. CRACK 175-101-21810
EAC0557

A Longstreet, and Phillips Bros.
D. Thompson, and others. A. A. A.
1 - 1/2, Max. Bros. Street - 1/2, 1st
Street, 1st St. 1st St.

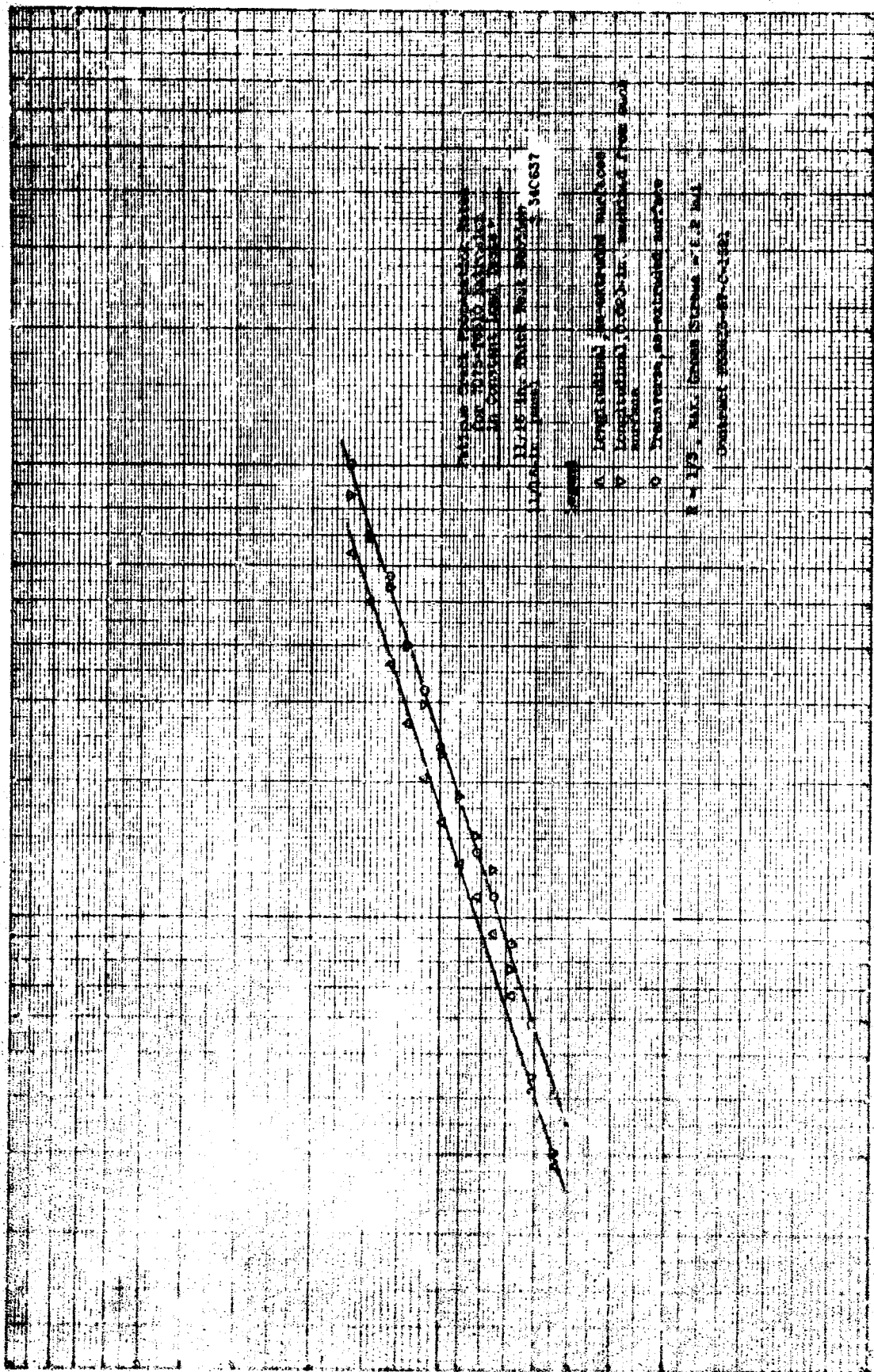
crack, Fatigue Crack Growth Rate, micro-in./cycle

100

tentative



A.1. Range of Stress Intensity Factor, 1000 psi sqrt(in)

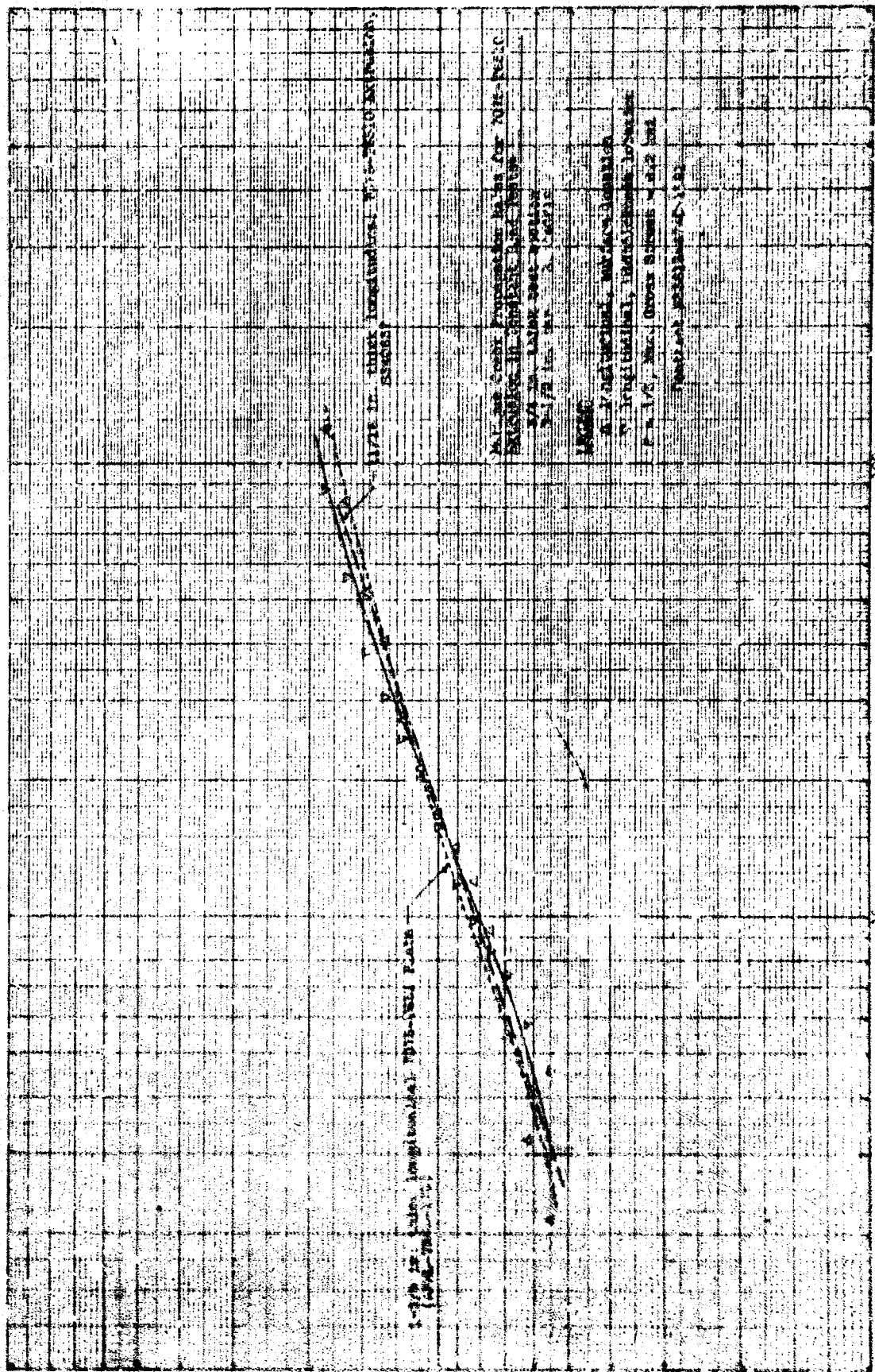


Tentative

100

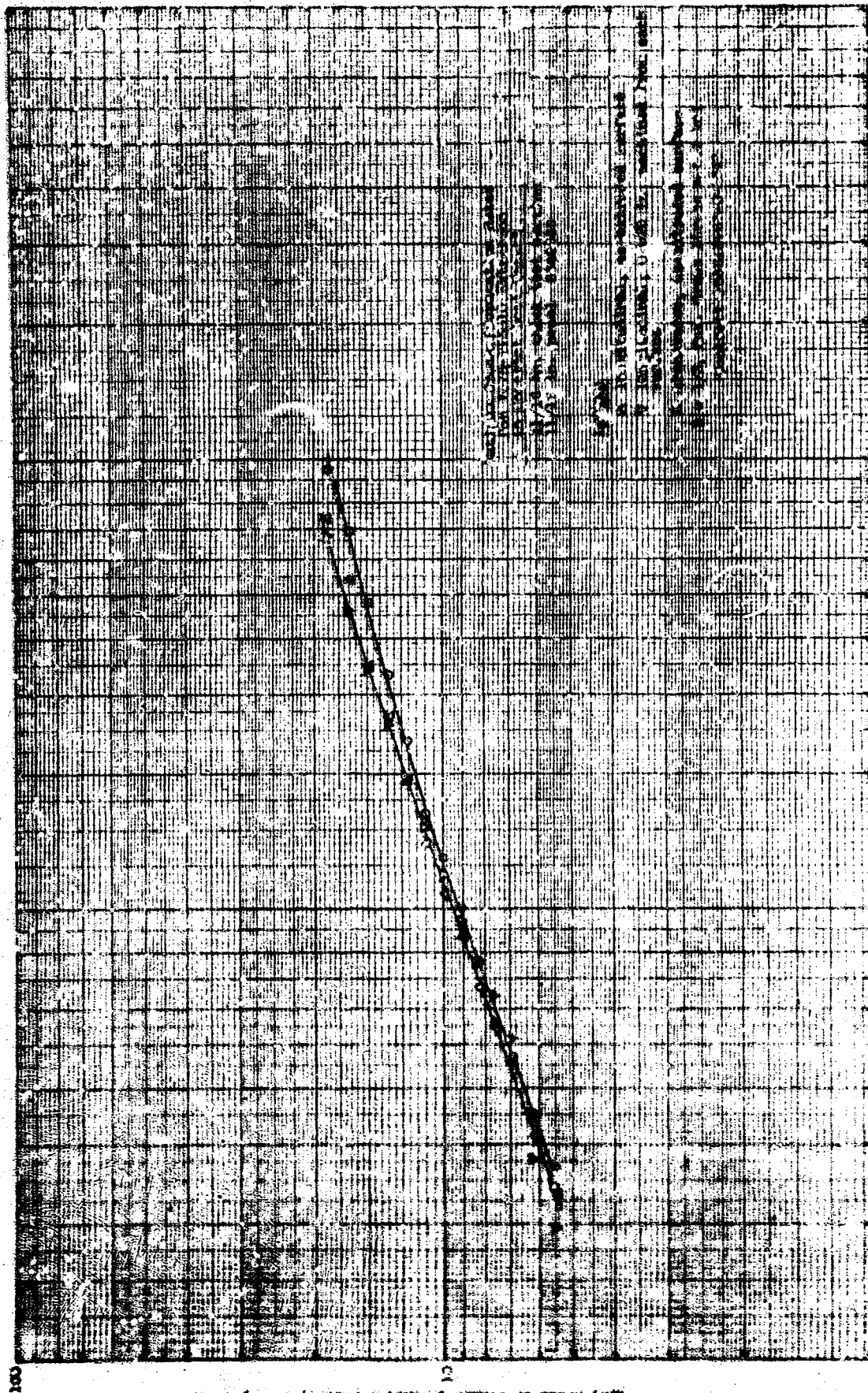
da/dN, Fatigue Crack Growth Rate, micro in./cycle

10



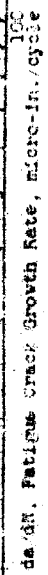
Tentative

Logarithmic Scale, micro in./cycle



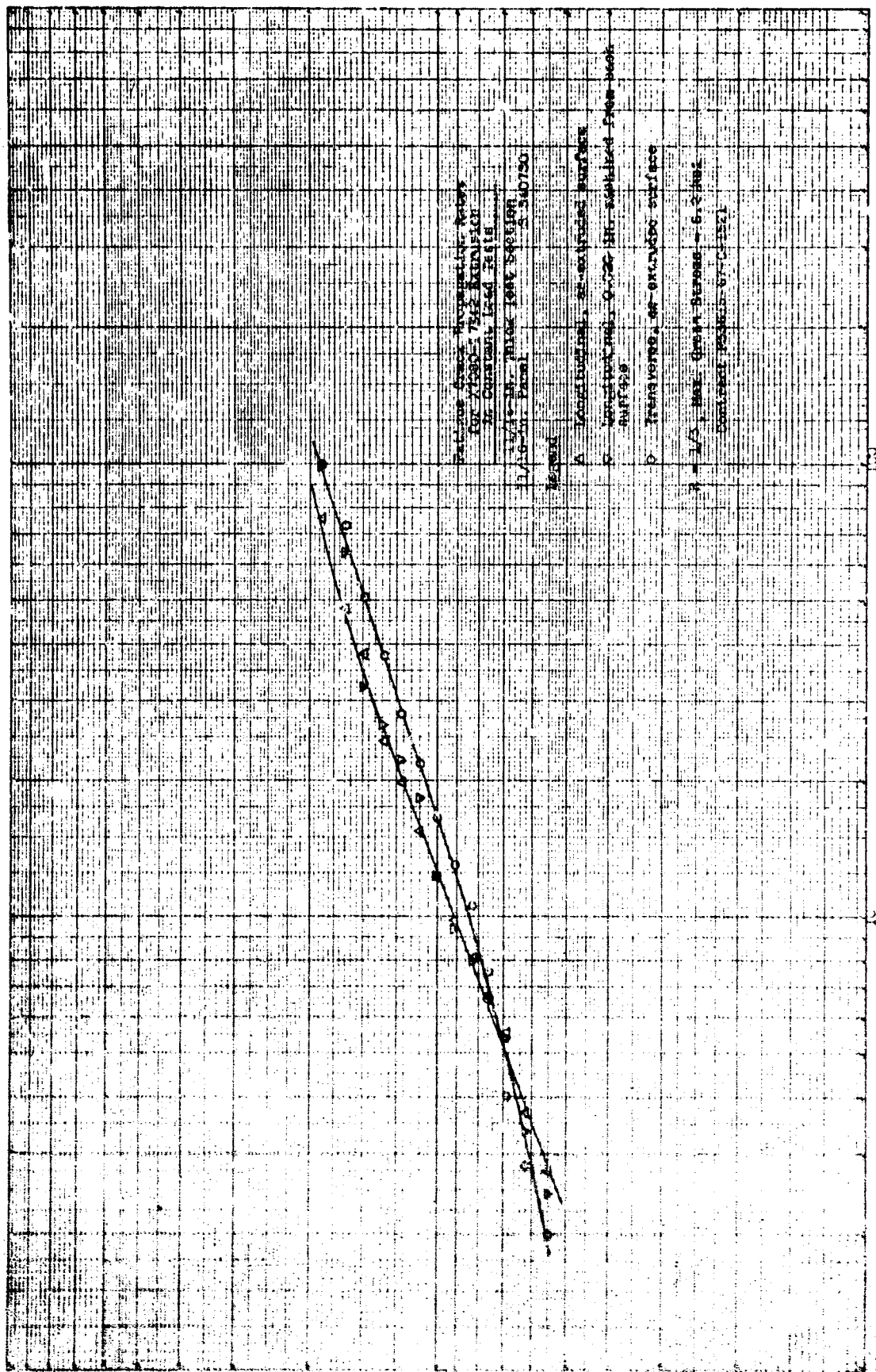
Iterative

Fig. 45



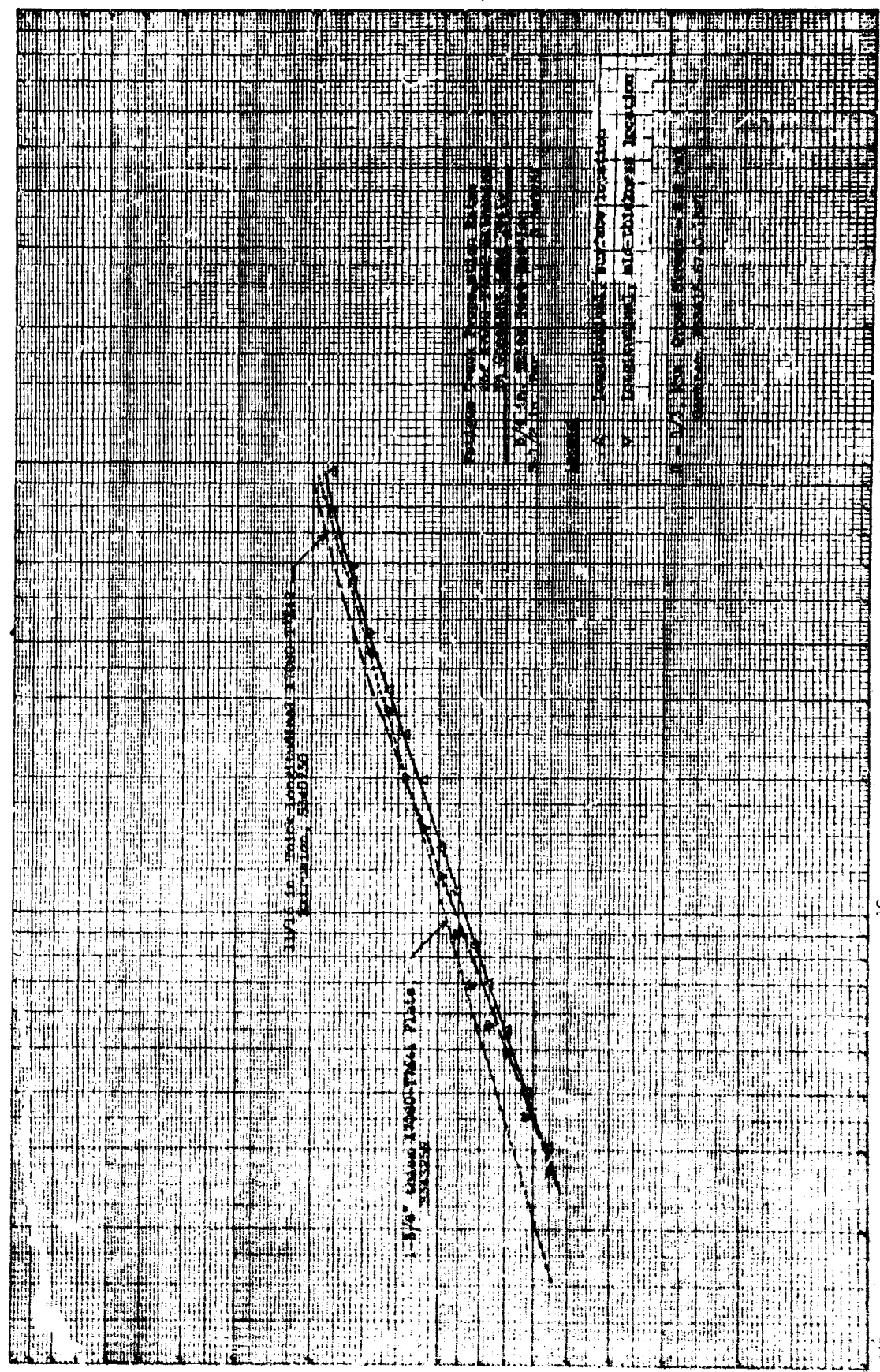
DATA FILE

Dr. Hume of Glasgow University writes, dated 17th



Tentative

da/dN: Fatigue Crack Growth Rate, micro-in./cycle



10⁻¹⁰ 10⁻²
da/dN, Fatigue Crack Growth Rate, micro-in./cycle

100

Tentative

Fig. 48

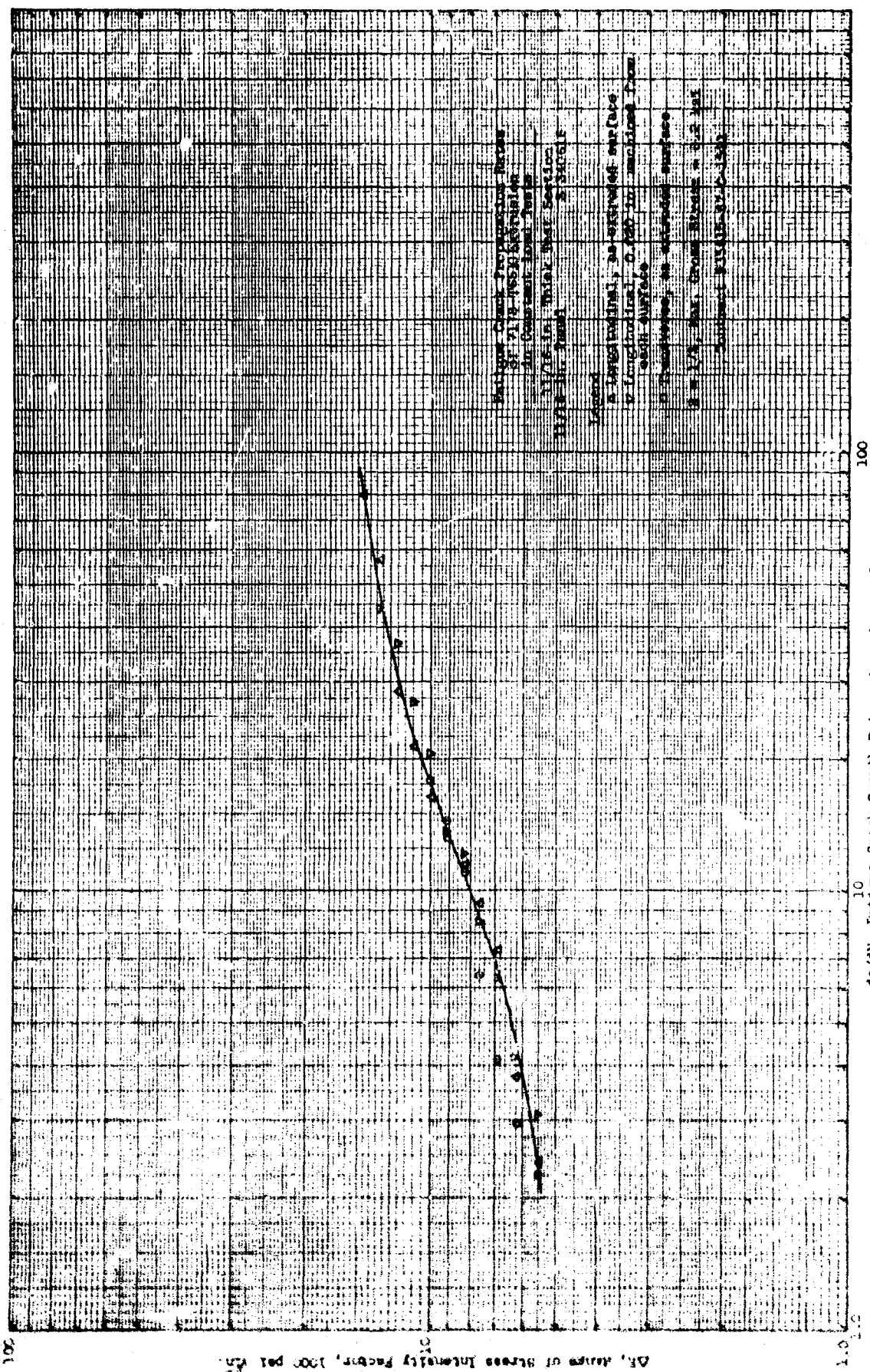
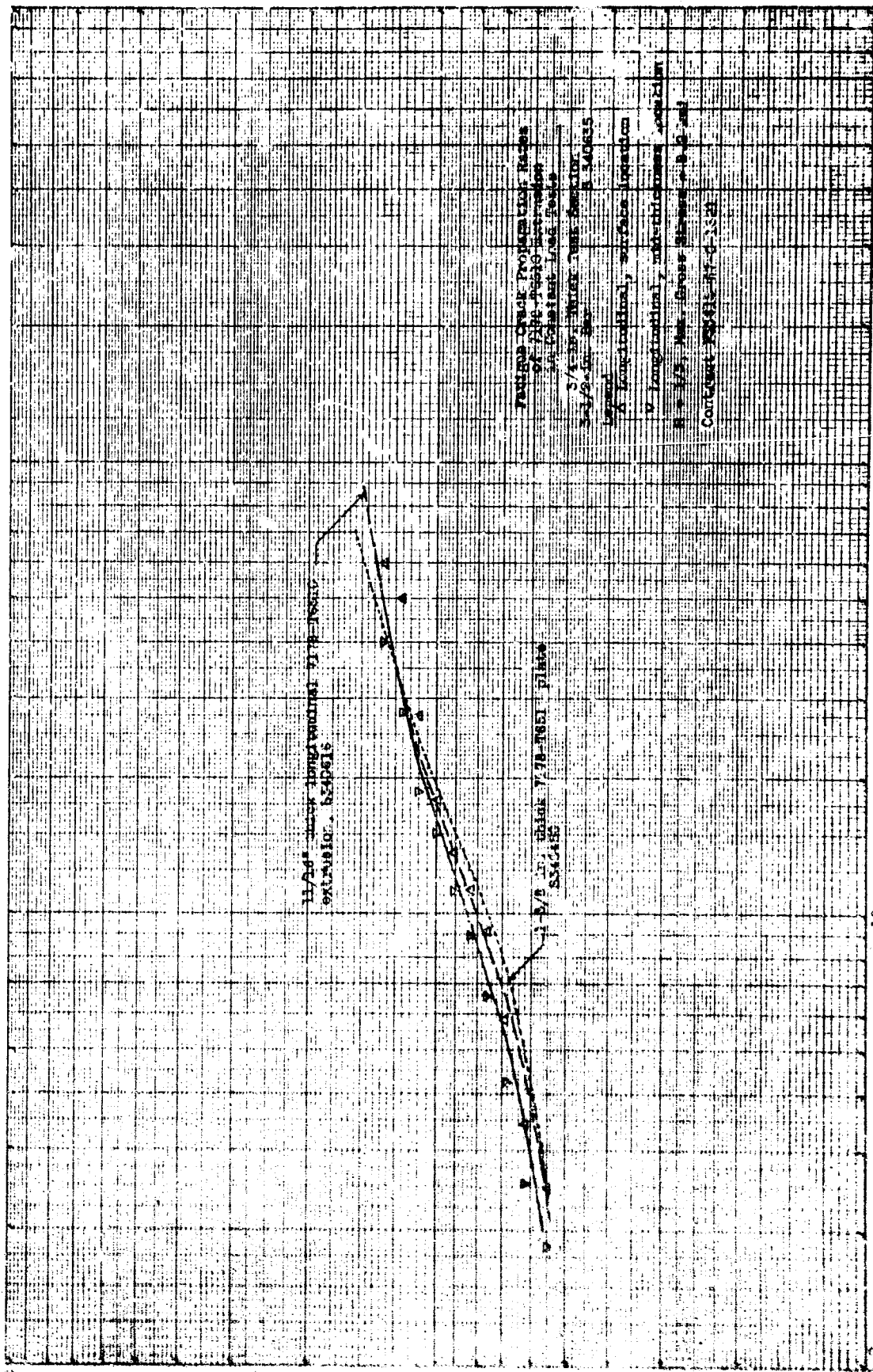
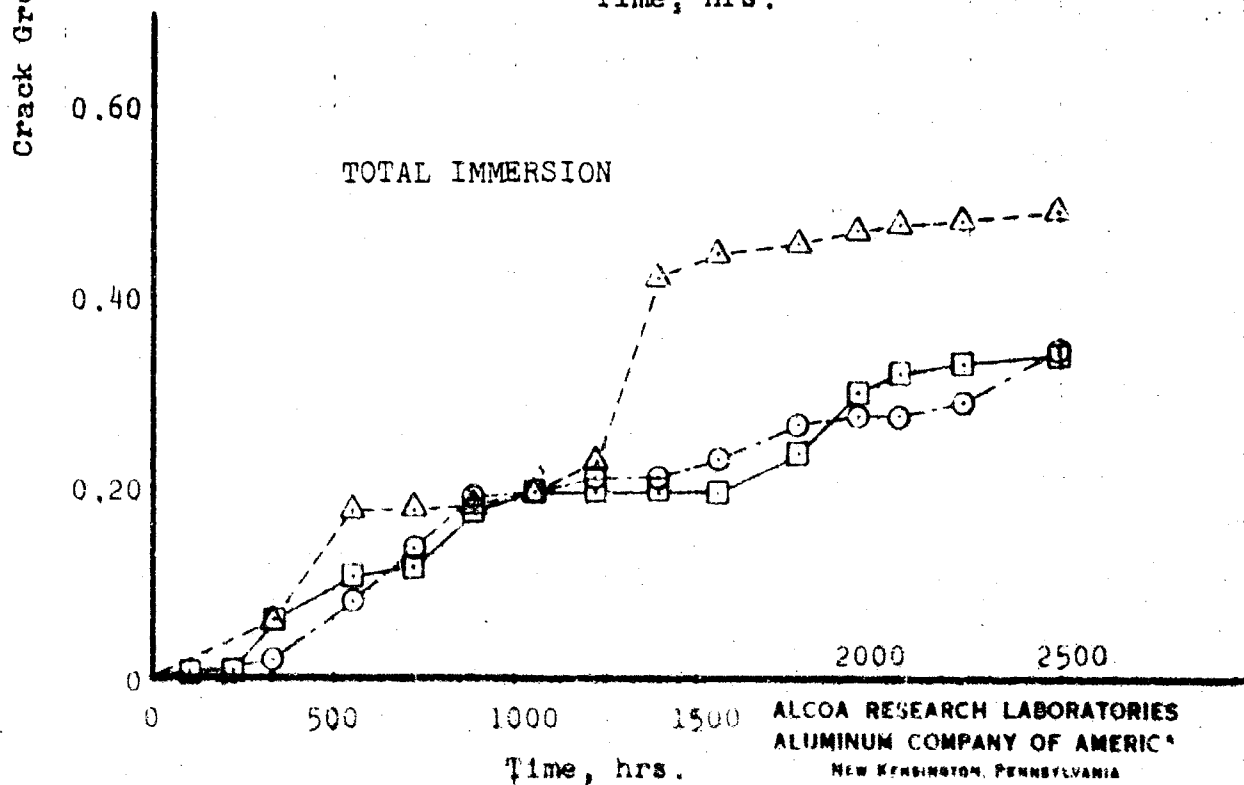
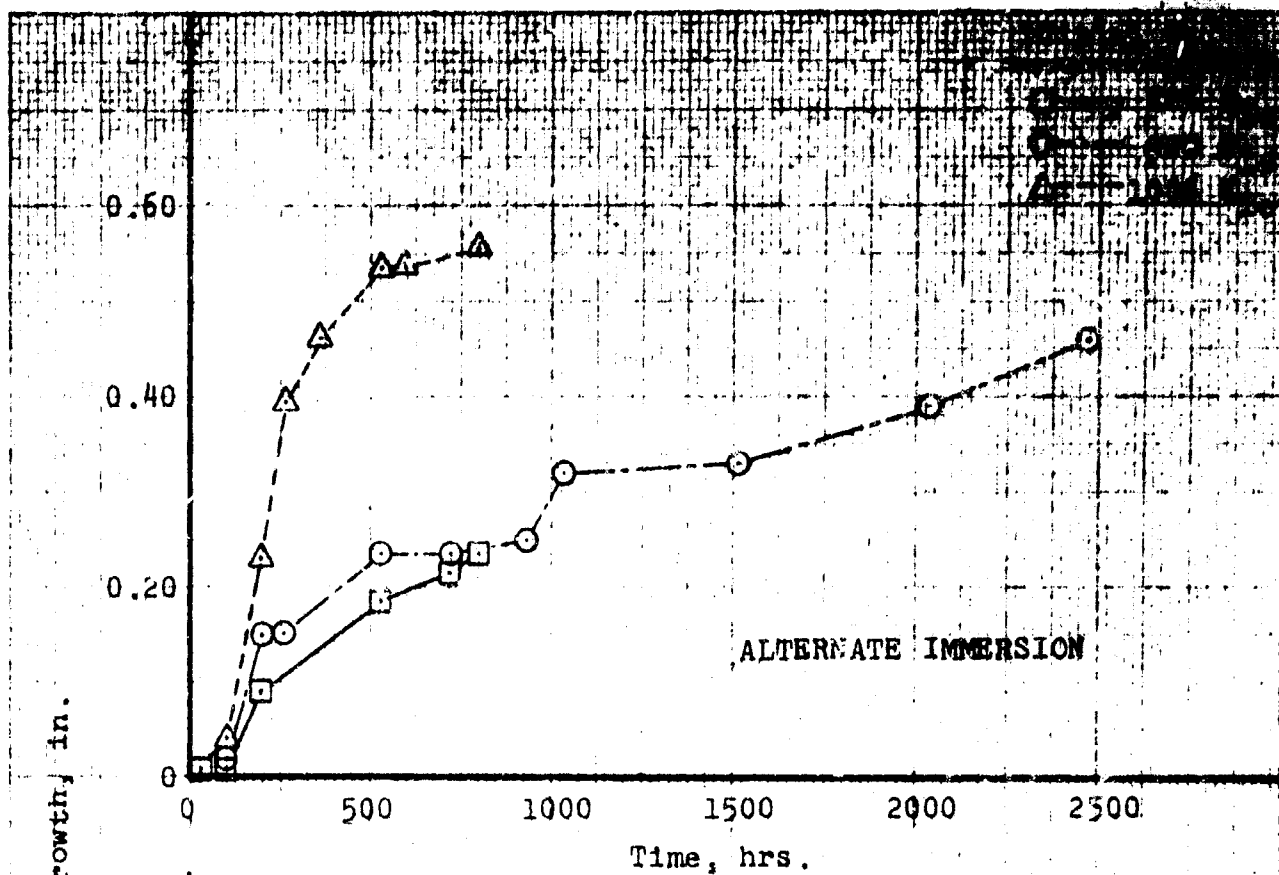


Fig. 49



da/dN, Fatigue Crack Growth Rate, micro in./cycle

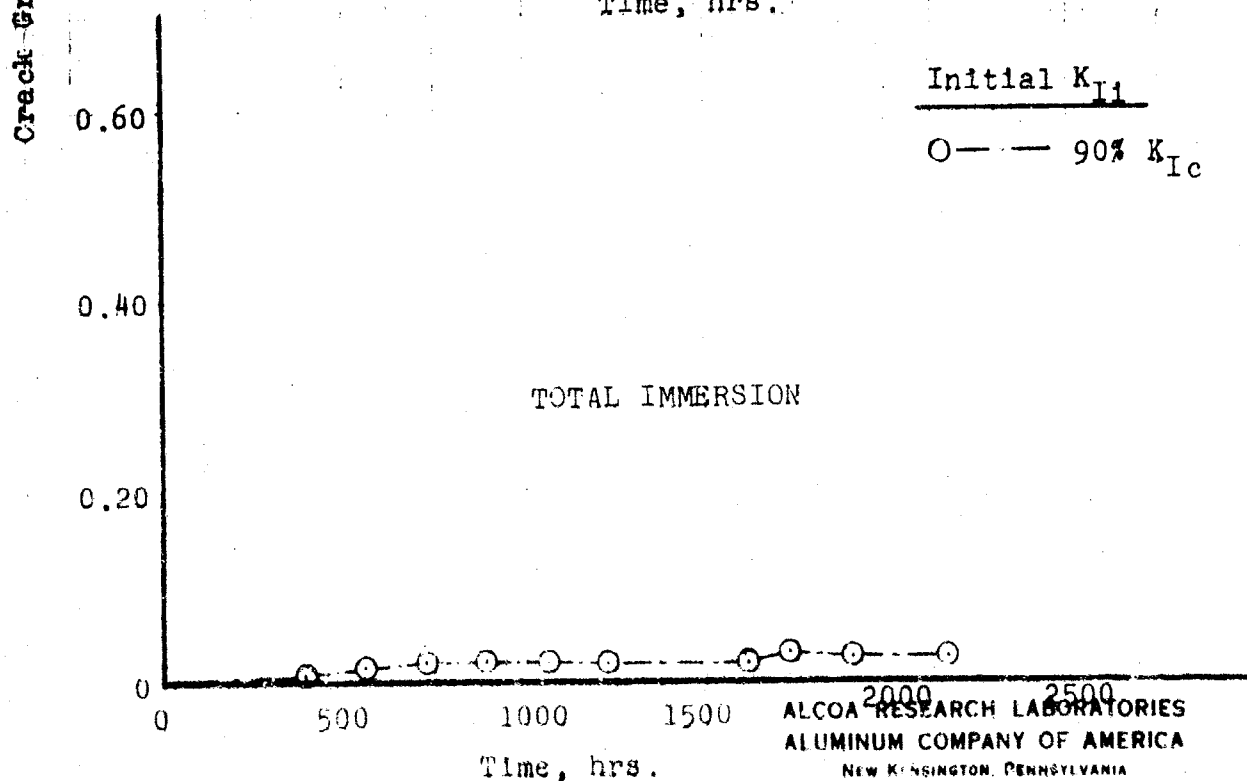
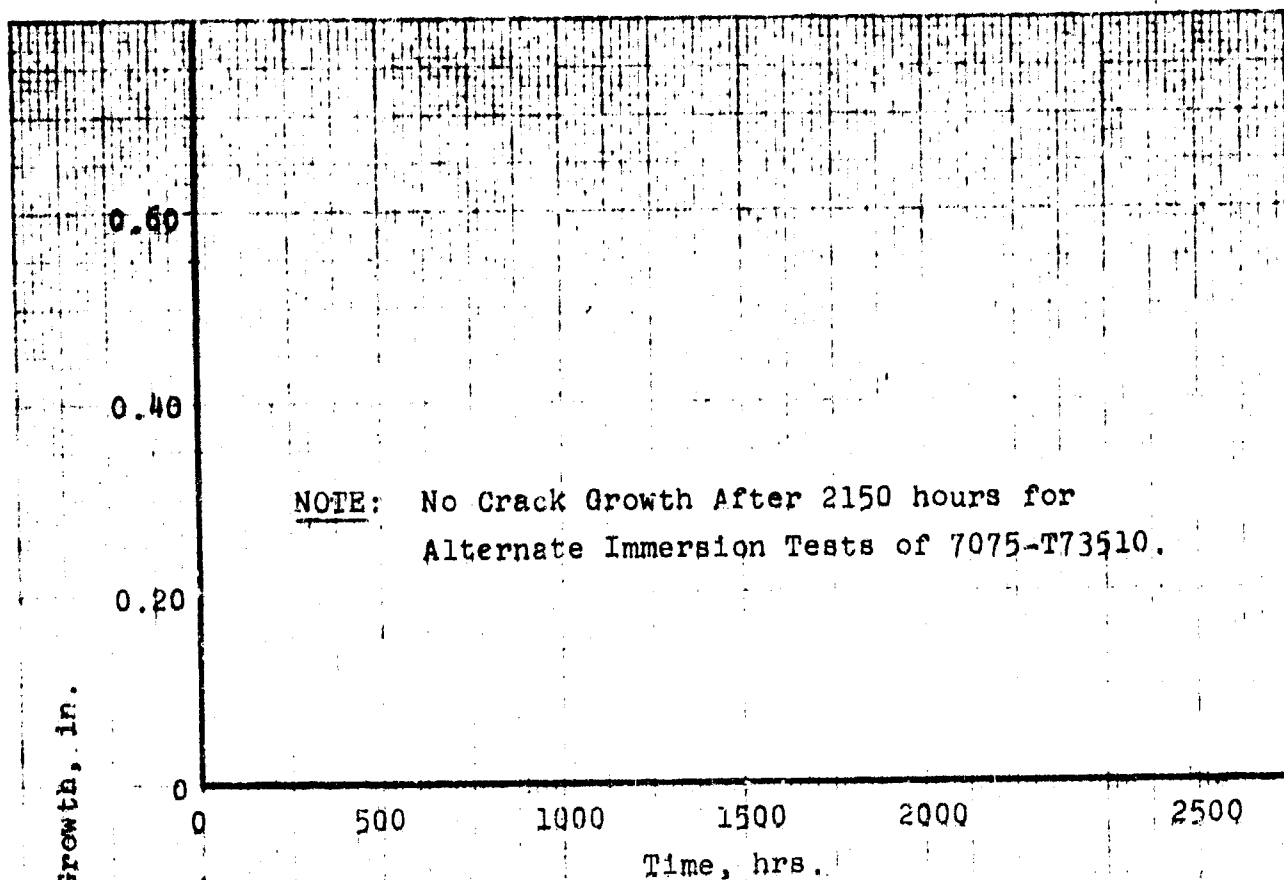


NOTES: Compact tension specimen
 Width = 2.00 in.
 Initial crack length =
 1.00±0.05 in.
 Single specimens were tested
 at each K_I level

Crack Growth vs Time in 3-1/2%
 NaCl Solution for Short-
 Transverse Bolt Loaded
 Specimens from 7075-T6510
 Extruded Bar

S. No. 340619

PLotted *[initials]* DATE *2/2/69* APPROVED *[initials]* DATE *2/2/69*

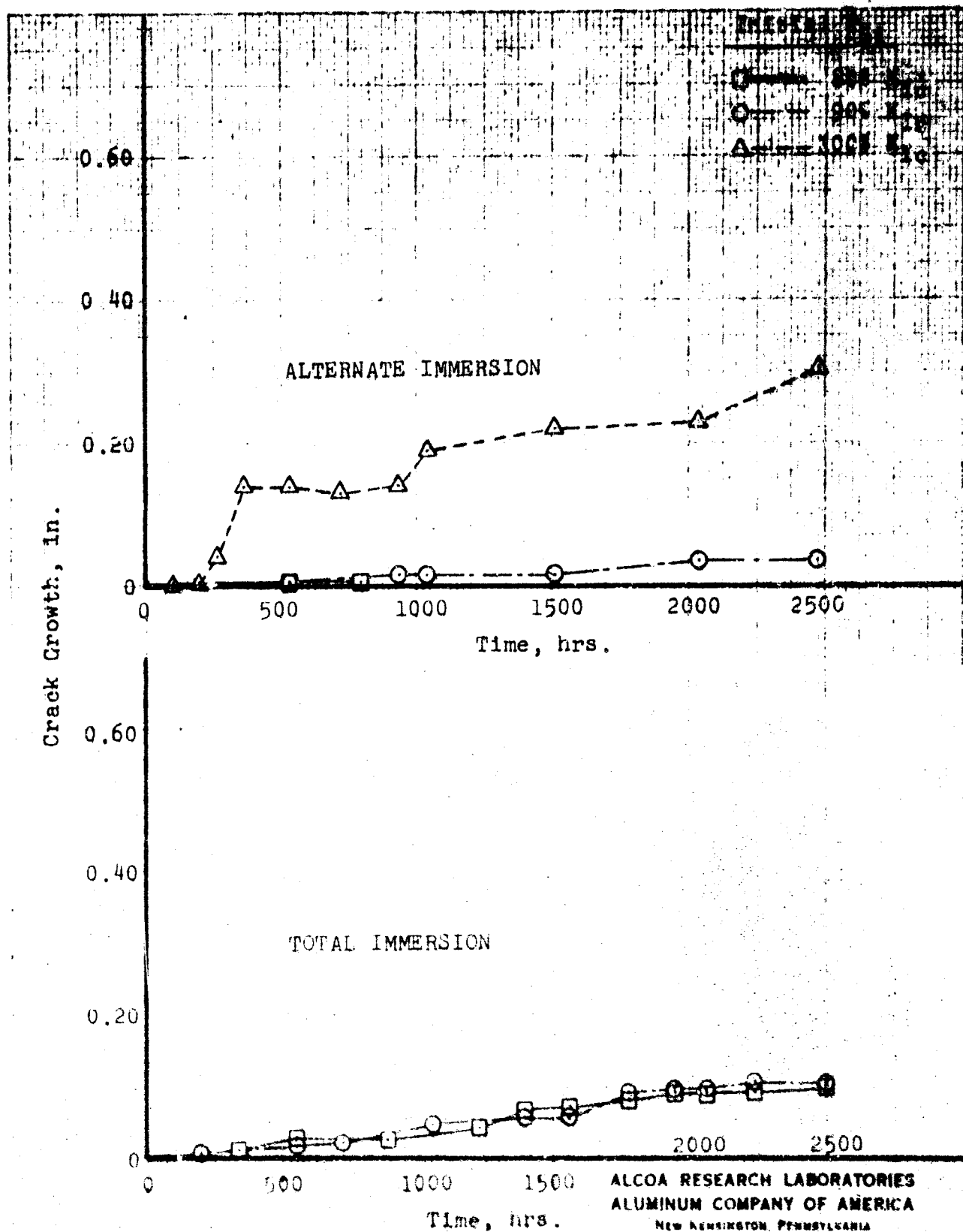


NOTES: Compact tension specimen
Width = 2.90 in.
Initial crack length =
1.00±0.05 in.
Single specimens were tested
at each K_I level

Crack Growth vs Time in 3-1/2%
NaCl Solution for Short-
Transverse Bolt Loaded
Specimens from 7075-T73510
Extruded Bar

S. No. 340620

PLOTTED *RW* DATE 456 APPROVED DATE

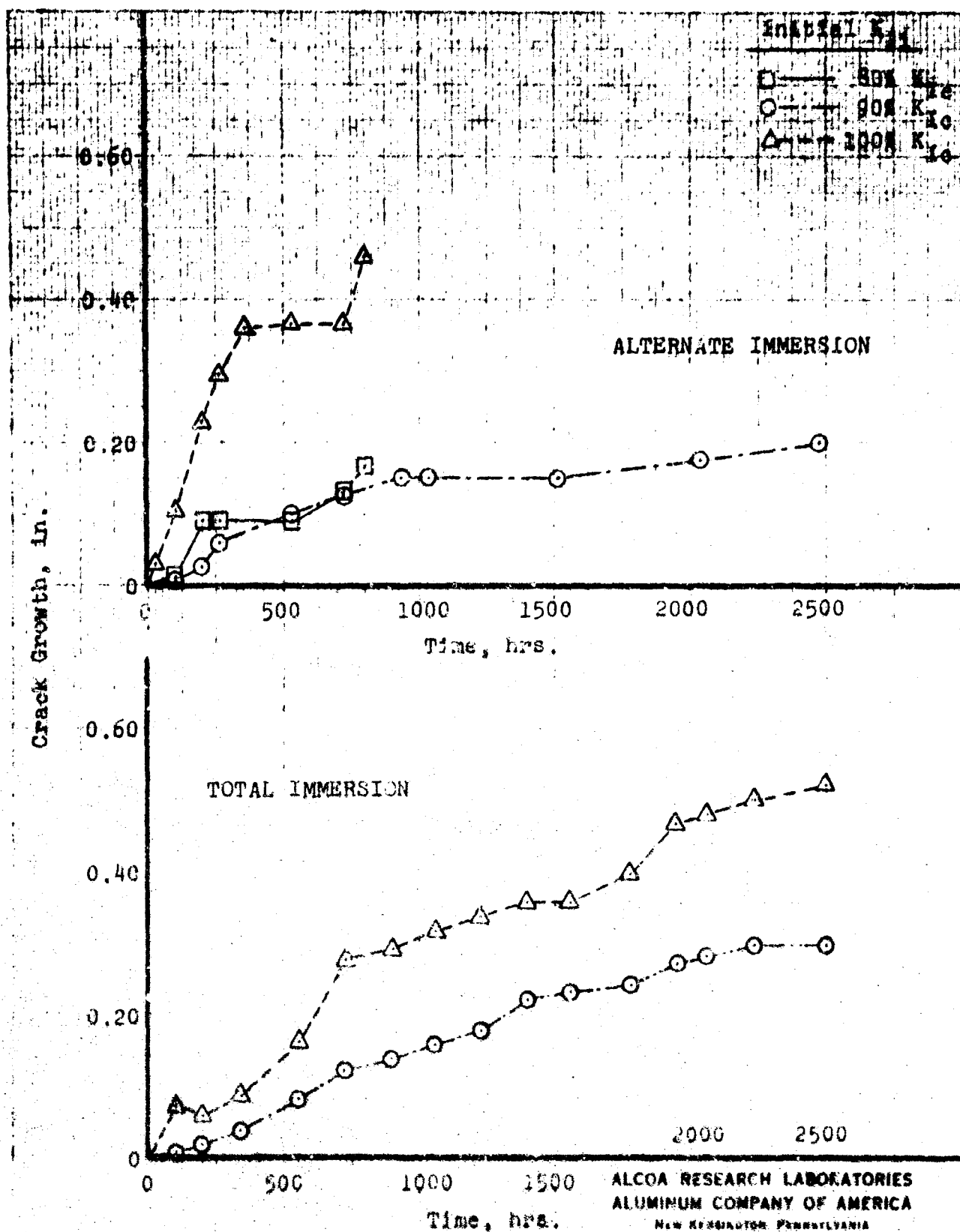


NOTES: Compact tension specimen
Width = 2.00 in.
Initial crack length =
1.00±0.05 in.
Single specimens were tested
at each K₁ level

Crack Growth vs Time in 3-1/2%
NaCl Solution for Short-
Transverse Bolt Loaded
Specimens from X7080-T7E42
Extruded Bar

S. No. 340732

PLOTTED BY DATE APPROVED DATE

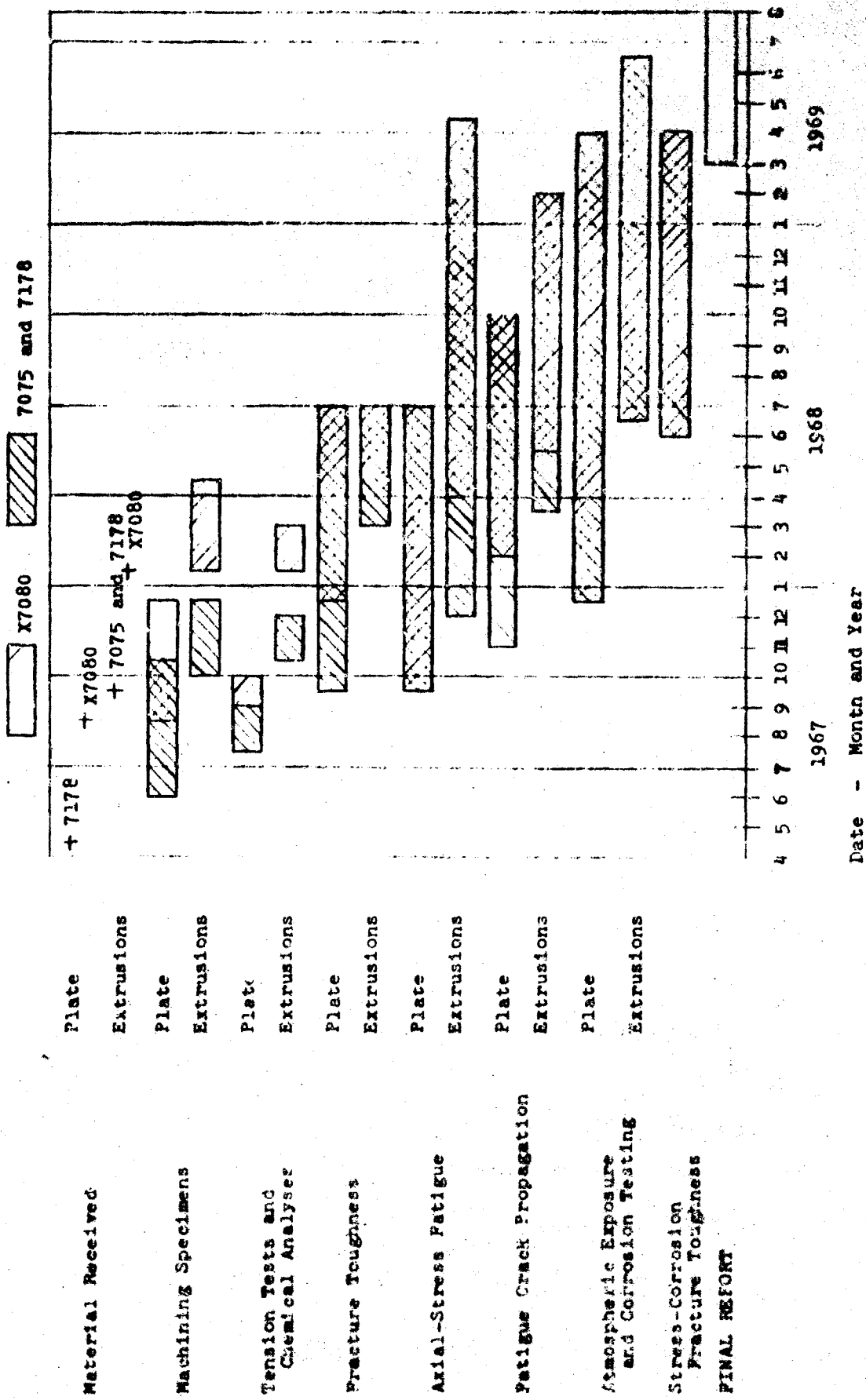


NOTES: Compact tension specimen
Width = 2.00 in.
Initial crack length =
1.00±0.05 in.
Single specimens were tested
at each K_I level

Crack Growth vs Time in 3-1/2%
NaCl Solution for Short-
Transverse Bolt Loaded
Specimens from 7178-T6510
Extruded Bar

S. No. 140645

PLOTTED AND DATA APPROVED DATE



Milestone Chart for Program on Fracture Toughness, Fatigue and Corrosion Characteristics of Aluminum Alloy Plate and Extrusions. (Contract F33615-67-C-1521)